

RULES AND REGULATIONS FOR THE CLASSIFICATION OF LINKSPANS

REGULATIONS

JULY 2008

PART 1

A guide to the Rules

and published requirements

Rules and Regulations for the Classification of Linkspans

Introduction

The Rules are published as a complete set, individual Parts are, however, available on request. A comprehensive List of Contents is placed at the beginning of each Part.

Numbering and Cross-References

A decimal notation system has been adopted throughout. Five sets of digits cover the divisions, i.e. Part, Chapter, Section, sub-Section and paragraph. The textual cross-referencing within the text is as follows, although the right hand digits may be added or omitted depending on the degree of precision required:

- (a) In same Chapter, e.g. see 2.1.3 (i.e. down to paragraph).
- (b) In same Part but different Chapter, e.g. see Ch 3,2.1 (i.e. down to sub-Section).
- (c) In another Part, e.g. see Pt 2, Ch 1,3 (i.e. down to Section).

The cross-referencing for Figures and Tables is as follows:

- (a) In same Chapter, e.g. as shown in Fig 2.3.5 (i.e. Chapter, Section and Figure Number).
- (b) In same Part but different Chapter, e.g. as shown in Fig. 2.3.5 in Chapter 2.
- (c) In another Part, e.g. see Table 2.7.1 in Pt 3, Ch 2.

Rules updating

The Rules are generally published annually and changed through a system of Notices. Subscribers are forwarded copies of such Notices when the Rules change.

Current changes to Rules that appeared in Notices are shown with a black rule alongside the amended paragraph on the left hand side. A solid black rule indicates amendments and a dotted black rule indicates corrigenda.

July 2008

CLASSIFICATION OF LINKSPANS

Rules and Regulations

July 2008

CLASSIFICATION

The following explanatory note is offered to assist those concerned in the application of these Rules and Regulations.

Explanatory Note

Ship classification may be regarded as the development and worldwide implementation of published Rules and Regulations which, in conjunction with proper care and conduct on the part of the Owner and operator, will provide for:

1. the structural strength of (and where necessary the watertight integrity of) all essential parts of the hull and its appendages;
2. the safety and reliability of the propulsion and steering systems; and
3. the effectiveness of those other features and auxiliary systems which have been built into the ship in order to establish and maintain basic conditions on board whereby appropriate cargoes and personnel can be safely carried whilst the ship is at sea, at anchor, or moored in harbour.

Lloyd's Register of Shipping (LR) maintains these provisions by way of the periodical visits by its Surveyors to the ship as defined in the Regulations in order to ascertain that the vessel currently complies with those Rules and Regulations. Should significant defects become apparent or damages be sustained between the relevant visits by the Surveyors, the Owner and operator are required to inform LR without delay. Similarly any modification which would affect Class must receive prior approval by LR.

A ship is said to be in Class when the Rules and Regulations which pertain to it have, in the opinion of LR, been complied with, or when special dispensation from compliance has been granted by LR.

It should be appreciated that, in general, classification Rules and Regulations do not cover such matters as the ship's floatational stability, life-saving appliances, pollution prevention arrangements, and structural fire protection, detection and extinction arrangements where these are covered by the *International Convention for the Safety of Life at Sea, 1974, its Protocol of 1978*, and the amendments thereto, nor do they protect personnel on board from dangers connected with their own actions or movement around the ship. This is because the handling of these aspects is the prerogative of the National Authority with which the ship is registered. A great many of these authorities, however, delegate such responsibilities to the Classification Societies who then undertake them in accordance with agreed procedures.

PART	1	REGULATIONS
		Chapter 1 General Regulations
		2 Classification Regulations
		3 Periodical Survey Regulations
PART	2	RULES FOR THE MANUFACTURE, TESTING AND CERTIFICATION OF MATERIALS
PART	3	CONSTRUCTION, DESIGN AND TESTING REQUIREMENTS
PART	4	ENGINEERING SYSTEMS

Contents

Part 1

CHAPTER	1	GENERAL REGULATIONS
Sections		1 to 8
CHAPTER	2	CLASSIFICATION REGULATIONS
Section	1	Conditions for classification
	1.1	General
	1.2	Application
	1.3	Scope of classification
	1.4	Interpretation of the Rules
	1.5	Client's responsibilities
Section	2	Withdrawal/Suspension of class
	2.1	Withdrawal of class
	2.2	Suspension of class
	2.3	Recording Withdrawal/Suspension of class
Section	3	Class characters and notations
	3.1	General
	3.2	Character symbols
	3.3	Class notations
	3.4	Other notations
	3.5	Descriptive notes
Section	4	Surveys and certificates
	4.1	Statutory surveys
	4.2	New construction surveys
	4.3	The first classification of existing linkspans not built under survey
	4.4	Reclassification of existing linkspans
	4.5	Existing linkspans – Periodical Surveys
	4.6	Damages, repairs and alterations
	4.7	Certificates
	4.8	Notice of surveys
	4.9	Survey of linkspans out of commission
	4.10	Appeal from Surveyors' recommendations
Section	5	IACS QSCS Audits
	5.1	Audit of surveys
CHAPTER	3	PERIODICAL SURVEY REGULATIONS
Section	1	General
	1.1	Frequency of surveys
	1.2	Surveys for damage or alterations
	1.3	Unscheduled surveys
	1.4	Definitions
Section	2	Annual Surveys – Structural and machinery
	2.1	General
	2.2	Annual Surveys
Section	3	Docking Surveys and In-Water Surveys – Structural and machinery requirements
	3.1	General
	3.2	Docking Surveys
	3.3	In-Water Surveys
Section	4	Intermediate Surveys – Structural and machinery requirements
	4.1	General
	4.2	Intermediate Surveys

Contents

Part 1

Section	5	Special Survey – Structural requirements
	5.1	General
	5.2	Preparation
	5.3	Examination and testing
	5.4	Thickness measurement
	5.5	Thickness measurement reporting
Section	6	Machinery Surveys – General requirements
	6.1	Annual, Intermediate and Docking Surveys and In-water Surveys
	6.2	Complete Surveys
Section	7	Electrical equipment surveys
	7.1	Annual and Intermediate Surveys
	7.2	Complete Surveys
Section	8	Initial classification of linkspans not built under survey
	8.1	General
	8.2	Structure
	8.3	Machinery

■ Section 1

1.1 Lloyd's Register (hereinafter referred to as 'LR'), which is recognized under the laws of the United Kingdom as a corporate body and a charity established for the benefit of the community, was founded in 1760. It was established for the purpose of producing a faithful and accurate Classification of Merchant Shipping. It now primarily produces Classification Rules.

1.2 Classification services are delivered to clients by a number of other members of the Lloyd's Register Group, including: Lloyd's Register EMEA, Lloyd's Register Asia, Lloyd's Register North America, Inc., and Lloyd's Register Central and South America Limited.

1.3 The Lloyd's Register Group (hereinafter referred to as 'the LR Group') comprises charities, other forms of organisation and non-charitable companies, with the latter supporting the charities in their main goal of enhancing the safety of life and property, at sea, on land and in the air, for the benefit of the public and the environment.

■ Section 2

2.1 LR remains the sole classification society in the LR Group. LR is managed by a corporate trustee Lloyd's Register Trustees Limited (hereinafter referred to as 'LR's trustee').

LR's trustee has:

Appointed a Classification Committee and determined its powers and functions;
Appointed Technical Committees and determined their powers, functions and duties.

2.2 The LR Group has established National and Area Committees in the following:

Countries:

Australia (via Lloyd's Register Asia)
Canada (via Lloyd's Register North America, Inc.)
China (via Lloyd's Register Asia)
Egypt (via Lloyd's Register EMEA)
Federal Republic of Germany
(via Lloyd's Register EMEA)
France (via Lloyd's Register EMEA)
Italy (via Lloyd's Register EMEA)
Japan (via Lloyd's Register Asia)
New Zealand (via Lloyd's Register Asia)
Poland (via Lloyd's Register (Polska) Sp zoo)
Spain (via Lloyd's Register EMEA)
United States of America (via Lloyd's Register North America, Inc.)

Areas:

Benelux (via Lloyd's Register EMEA)
Central America (via Lloyd's Register Central and
South America Ltd)
Nordic Countries (via Lloyd's Register EMEA)
South Asia (via Lloyd's Register Asia)
Asian Shipowners (via Lloyd's Register Asia)
Greece (via Lloyd's Register EMEA)

General Regulations

Part 1, Chapter 1

Section 3

■ Section 3

3.1 LR's Technical Committee is at present composed of:

Ex officio members:

	TOTAL
• The Chairman of Lloyd's Register Holdings (LRH)	1
• The Chairman of the Classification Committee	1

Members Nominated by:

• The General Committee of Trustees of LRH	18
• The Royal Institution of Naval Architects	2
• The Institution of Engineers and Shipbuilders in Scotland	2
• The Institute of Marine Engineers	2
• The Institution of Mechanical Engineers	2
• The Shipbuilders' and Shiprepairers' Association	2
• The Short Sea Group of the Chamber of Shipping	1
• The Society of Consulting Marine Engineers and Ship Surveyors	1
• The Institute of Materials	1
• The UK Steel Association	1
• The Honourable Company of Master Mariners	2
• The Institution of Electrical Engineers	1
• Federation of British Electrotechnical and Allied Manufacturers' Associations	1
• The Technical Committee	18
• The Technical Committee (from other countries)	18
• The Institute of Refrigeration	1
• International Oil Companies	2
• Association of European Shipbuilders and Shiprepairers	1
• Greek Shipping Co-operation Committee	1
	<u>79</u>

3.2 In addition to the foregoing:

- Each National or Area Committee may appoint a representative to attend meetings of the Technical Committee.
- A maximum of five representatives from National Administrations may, with the consent of the Technical Committee, be co-opted to serve on the Technical Committee. Such representatives may also be elected as members of the Technical Committee under one of the categories identified in 3.1.
- Further persons may, with the consent of the Technical Committee, be co-opted to serve on the Technical Committee.

3.3 All elections are subject to confirmation by LR's trustee.

3.4 The function of the Technical Committee is to consider any technical problems connected with LR's business and with the exception of changes necessitated by mandatory implementation of International Conventions, Codes or Unified Requirements adopted by the International Association of Classification Societies, any proposed alterations in the existing Rules and to frame new Rules for classification as deemed necessary.

3.5 The term of office of the Chairman and of all members of the Technical Committee is five years. Members may serve one additional term of office with the approval of LR's trustee. The term of the Chairman may be extended with the approval of LR's trustee.

3.6 In the case of continuous non-attendance of a member, the Technical Committee may withdraw his/her membership.

3.7 Meetings of the Technical Committee are convened as often and at such times and places as is necessary, but there is to be at least one meeting in each year.

3.8 Any proposal of the Technical Committee involving any alteration in, or addition to, Rules for Classification is referred to LR's Trustee which has agreed to seek the comments of the Lloyd's Register Holding's General Committee of Trustees before adopting the proposal.

3.9 The Technical Committee is empowered to:

- appoint sub-Committees or panels; and
- co-opt to the Technical Committee, or to its sub-Committees or panels, representatives of any organization or industry or private individuals for the purpose of considering any particular problem.

General Regulations

Part 1, Chapter 1

Sections 4 & 5

■ Section 4

4.1 LR's Naval Ship Technical Committee (hereinafter referred to as 'the NSTC') is at present composed of up to 50 members and includes nominees of:

- The Royal Navy and the UK Ministry of Defence;
- The Defence Evaluation and Research Agency;
- UK Shipbuilders, Ship Repairers and Defence Industry;
- Overseas Governments and Governmental Agencies;
- Overseas Shipbuilders, Ship Repairers and Defence Industries;
- Various maritime bodies and institutions, nominated by the NSTC;
- The Chairman of LRH and Chairman of the Classification Committee who are ex officio members.

4.2 All elections are subject to confirmation by LR's trustee.

4.3 All members of the NSTC are to hold security clearance from their National Authority for the equivalent of NATO CONFIDENTIAL. All material is to be handled in accordance with NATO Regulations or, for non-NATO countries, an approved equivalent. No classified material shall be disclosed to any third party without the consent of the originator.

4.4 The term of office of the NSTC Chairman and of all members of the NSTC is five years. Members may serve one additional term of office with the approval of LR's trustee. The term of the Chairman may be extended with the approval of LR's trustee.

4.5 In the case of continuous non-attendance of a member, the NSTC may withdraw that person's membership.

4.6 The function of the NSTC is to consider technical issues connected with Naval Ship matters and to approve proposals for new Naval Ship Rules, or amendments to existing Naval Ship Rules.

4.7 Meetings of the NSTC are convened as necessary but there will be at least one meeting per year.

4.8 Following approval by the NSTC, details of new Rules (or amendments) will be submitted to LR's trustee which will seek comments from LRH's General Committee of Trustees before adopting any changes.

■ Section 5

5.1 LR has the power to adopt, and publish as deemed necessary, Rules relating to Classification and has (in relation thereto) provided the following:

- (a) Except in the case of a special directive by LR's trustee, no new Regulation or alteration to any existing Regulation relating to classification or to class notations is to be applied to existing ships.
- (b) Except in the case of a special directive by LR's trustee, or where changes necessitated by mandatory implementation of International Conventions, Codes or Unified Requirements adopted by the International Association of Classification Societies are concerned, no new Rule or alteration in any existing Rule is to be applied compulsorily after the date on which the contract between the ship builder and shipowner for construction of the ship has been signed, nor within six months of its adoption. The date of 'contract for construction' of a ship is the date on which the contract to build the ship is signed between the prospective shipowner and the ship builder. This date and the construction number (i.e. hull numbers) of all the vessels included in the contract are to be declared by the party applying for the assignment of class to a newbuilding. The date of 'contract for construction' of a series of sister ships, including specified optional ships for which the option is ultimately exercised, is the date on which the contract to build the series is signed between the prospective shipowner and the ship builder. In this section a "series of sister ships" is a series of ships built to the same approved plans for classification purposes, under a single contract for construction. The optional ships will be considered part of the same series of sister ships if the option is exercised not later than 1 year after the contract to build the series was signed. If a contract for construction is later amended to include additional ships or additional options, the date of 'contract for construction' for such ships is the date on which the amendment to the contract is signed between the prospective shipowner and the ship builder. The amendment to the contract is to be considered as a 'new contract'. If a contract for construction is amended to change the ship type, the date of 'contract for construction' of this modified vessel, or vessels, is the date on which the revised contract or new contract is signed between the Owner, or Owners, and the shipbuilder. Where it is desired to use existing approved ship or machinery plans for a new contract, written application is to be made to LR. Sister ships may have minor design alterations provided that such alterations do not affect matters related to classification.
- (c) That it will, in all cases, consult with LRH's General Committee of Trustees before passing any Rule amendment.

General Regulations

Part 1, Chapter 1

Sections 5 to 8

- (d) All reports of survey are to be made by Surveyors authorised by members of the LR Group to survey and report (hereinafter referred to as 'the Surveyors') according to the form prescribed, and submitted for the consideration of the Classification Committee.
- (e) Information contained in the reports of classification and statutory surveys will be made available to the relevant owner, National Administration, Port State Administration, P&I Club, hull underwriter and, if authorized in writing by that owner, to any other person or organization.
- (f) Information relating to the status of classification and statutory surveys and suspensions/withdrawals of class together with any associated conditions of class will be made available as required by applicable legislation or court order.
- (g) A Classification Executive consisting of senior members of LR's Classification Department staff shall carry out whatever duties that may be within the function of the Classification Committee that the Classification Committee assigns to it.

■ Section 6

6.1 No LR Group employee is permitted under any circumstances, to accept, directly or indirectly, from any person, firm or company, with whom the work of the employee brings the employee into contact, any present, bonus, entertainment or honorarium of any sort whatsoever which is of more than nominal value or which might be construed to exceed customary courtesy extended in accordance with accepted ethical business standards.

■ Section 7

7.1 LR has power to withhold or, if already granted, to suspend or withdraw any class (or to withhold any certificate or report in any other case), in the event of non-payment of any fee to any member of the LR Group.

■ Section 8

8.1 When providing services LR does not assess compliance with any standard other than the applicable LR Rules, international conventions, and other standards agreed in writing.

8.2 In providing services, information or advice, the LR Group does not warrant the accuracy of any information or advice supplied. Except as set out herein, LR will not be liable for any loss, damage or expense sustained by any person and caused by any act, omission, error, negligence or strict liability of any of the LR Group or caused by any inaccuracy in any information or advice given in any way by or on behalf of the LR Group even if held to amount to a breach of warranty. Nevertheless, if the Client uses LR's services or relies on any information or advice given by or on behalf of the LR Group and as a result suffers loss, damage or expense that is proved to have been caused by any negligent act, omission or error of the LR Group or any negligent inaccuracy in information or advice given by or on behalf of the LR Group, then a member of the LR Group will pay compensation to the client for its proved loss up to but not exceeding the amount of the fee (if any) charged for that particular service, information or advice.

8.3 Notwithstanding the previous clause, the LR Group will not be liable for any loss of profit, loss of contract, loss of use or any indirect or consequential loss, damage or expense sustained by any person caused by any act, omission or error or caused by any inaccuracy in any information or advice given in any way by or on behalf of the LR Group even if held to amount to a breach of warranty.

8.4 Any dispute about LR's services is subject to the exclusive jurisdiction of the English courts and will be governed by English law.

Classification Regulations

Part 1, Chapter 2

Section 1

Section

- 1 **Conditions for classification**
- 2 **Withdrawal/Suspension of class**
- 3 **Class characters and notations**
- 4 **Surveys and certificates**
- 5 **IACS QSCS Audits**

■ Section 1 Conditions for classification

1.1 General

1.1.1 The *Rules and Regulations for the Classification of Linkspans*, hereinafter referred to as the Rules, are applicable to those types of facilities which are defined in 1.2.1.

1.1.2 Assignment of classification will, on compliance with these Rules, be granted by the Committee on the basis that the designers, builders, repairers, Owners and operators of the linkspan:

- (a) bear the prime responsibility for all the safety-related aspects of the linkspan which fall within the scope of their intervention;
- (b) have fully acquainted themselves with the scope of these Rules and the associated obligations laid down herein;
- (c) have satisfied themselves that these Rules are sufficient for their purposes;
- (d) are aware of their obligations under all National and International codes and statutory requirements which may be applicable.

1.1.3 The Rules are based on the understanding that:

- (a) the linkspan will, at all times, be properly loaded in accordance with the designer's instructions and the loading conditions approved by LR;
- (b) the linkspan will, at all times, be properly operated by trained and authorized personnel;
- (c) the linkspan will be maintained by qualified and authorized personnel;
- (d) compliance with the Rules does not relieve the designers and/or builders/contractors of their contractual responsibilities to their Client for compliance with the specification and the requirements for the overall design and in-service performance of the linkspan;
- (e) the linkspan will not be operated outside the parameters specified in the approval and in the class notation without the prior agreement of LR.

1.1.4 New linkspans which are designed, constructed and installed in accordance with the Rules, will be assigned a class and will continue to be classed so long as they are found, upon examination at the prescribed surveys, to be maintained in accordance with the requirements of the Rules to the satisfaction of the Committee. Classification will be conditional upon compliance with all requirements of LR.

1.1.5 The class notations of these linkspans will be recorded in the *Maritime Guide*. See also Section 3.

1.1.6 LR will require to be satisfied that linkspans are suitable for the environmental conditions at the intended geographical service locations and which may not apply if the linkspan is moved to a different location.

1.1.7 Any damage, defect, breakdown or grounding, which could adversely affect the ability of the linkspan to accommodate the conditions for which a class has been assigned, is to be reported to LR by its client without delay.

1.2 Application

1.2.1 These Rules apply to the classification of linkspans which, unless formally agreed otherwise by LR, are defined as follows:

Linkspans are non-self-propelled marine facilities, sited at fixed locations normally within protected waters (see 1.2.5), for the transfer of vehicular and/or passenger traffic between shore and ship.

For the purposes of this definition a linkspan may be:

- a floating structure or may derive its support from non-buoyant means, or a combination of both;
- linked to the shore by a single or multiple system of bridges, ramps or walkways;
- held on station by a mooring system or a tethering arrangement consisting of a system of guidepiles or dolphins, or other tethering arrangements, see 1.3.4.

1.2.2 Classification in accordance with these Rules is normally assigned on the basis that the linkspan will not fulfil any station-keeping function for the ships which use it. Should any such station-keeping function be contemplated, full details are to be submitted at the earliest possible stage so that the feasibility of the proposal can be considered. The classification of any such linkspan will be specially considered.

1.2.3 If it is intended, despite the definition given in 1.2.1, to operate a linkspan at a location outside protected waters, full details are to be submitted at the earliest possible stage in order to establish the feasibility of the proposal. The classification of any such linkspan will be specially considered.

1.2.4 These Rules do not apply to the classification of ship-mounted ramps. For ship-mounted ramps, see Pt 3, Ch 9,3 of the *Rules and Regulations for the Classification of Ships* (hereinafter referred to as the Rules for Ships) and Ch 5,3 of the *LR Code for Lifting Appliances in a Marine Environment* (LAME Code).

Classification Regulations

Part 1, Chapter 2

Section 1

1.2.5 For the purposes of these Rules, protected water is defined as an area which, if connected to open water, is substantially shielded from the sea states associated with the open water by the configurations of the land and/or infrastructure which partially surround the area. In any particular situation, the degree of protection required depends on the severity of the open water sea states to be attenuated and on the structural sensitivity of the items within the area to be protected. This is a question of judgement which, when doubt exists, will normally require resolution by the measures indicated in Pt 3, Ch 1,2.1.1. Open water is an area having a fetch in excess of six nautical miles.

1.2.6 These Rules may not apply to ramps, bridges and walkways which are intended to be mechanically hoisted and lowered when loaded with vehicles or passengers. If it is intended that they may be mechanically hoisted or lowered when loaded with passengers or vehicles then that element will be treated as a lifting appliance and the requirements of the appropriate sections of LR's LAME Codes will also apply. Additionally, other National Standards may be applicable.

1.2.7 For the purposes of these Rules the term machinery is to cover all aspects of engineering systems described in Part 4.

1.2.8 For the purposes of these Rules the term ship is to be taken to cover any type of marine craft suitable for the installation.

1.2.9 For the purposes of these Rules the term walkway is to be taken to cover any type of walkway which is part of the linkspan and is designed to be used by passengers and others for boarding a ship. It does not include walkways/platforms/ladders, etc., solely provided for service/maintenance/inspection purposes of the linkspan or any walkways which are not part of the linkspan such as ships' gangways, accommodation ladders, brows and pilot ladders.

1.2.10 For the purposes of these Rules the term operators is taken to mean the authority or authorities appointed to manage the operation and maintenance of the linkspan. The operators may be the Owners of the linkspan.

1.2.11 For the purposes of these Rules the term passenger in relation to a walkway is to include all persons, and where appropriate animals, who may use that walkway.

1.3 Scope of classification

1.3.1 Classification covers the design, construction and Periodical Survey of the linkspan to the extent indicated within the Rules. However, coverage may, in special circumstances, and by formal agreement with LR, be extended to cover the further aspects indicated in 1.2.2, 1.2.3, 1.2.4, 1.2.5 and 1.2.6.

1.3.2 For each such aspect the extent of LR classification coverage is strictly limited to the requirements indicated in these Rules, and it is achieved by way of the intervention of LR Surveyors at the appropriate stages of design, construction, installation, commissioning, and, periodically, during service.

1.3.3 The in-service stability of the linkspan is the responsibility of the operators.

1.3.4 Interface works, such as the bankseats, guide-piles or dolphins and anchors, and the associated sea-bed conditions, where applicable, and approach roads and bridges are not within the scope of classification. Components of the mooring/tethering arrangement such as chains, mooring ropes and mooring arm structures are to comply with the requirements of Pt 3, Ch 7. Fig. 2.1.1(a), (b) and (c) indicates items included in classification (lighter shading) and those outwith classification (darker shading).

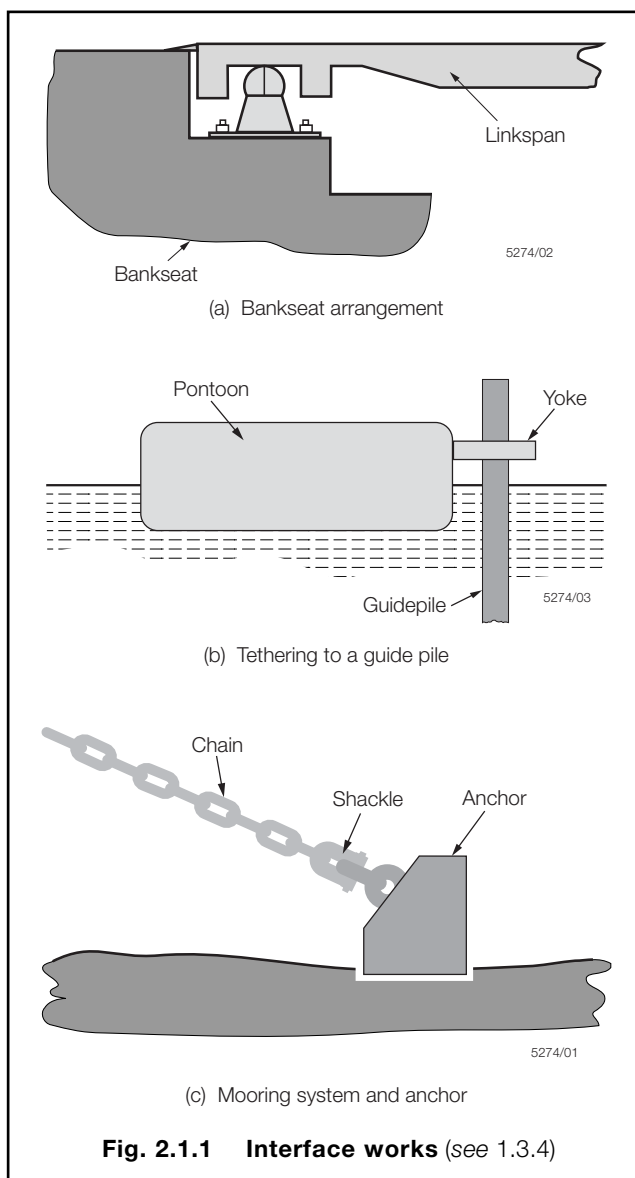


Fig. 2.1.1 Interface works (see 1.3.4)

Classification Regulations

Part 1, Chapter 2

Sections 1 & 2

1.3.5 Where a linkspan is so badly damaged that class has to be suspended, LR is prepared to assist the operators with advice on measures to be taken for re-classification, if requested.

1.3.6 The attention of Owners/operators, builders and designers is drawn to statutory requirements which may be imposed by the relevant National Administration and which may not be within the scope of classification. If there is any conflict between local statutory requirements and those of LR then the local requirements would take priority without necessarily affecting LR Classification, provided the structural strength and safety aspects are not compromised.

1.4 Interpretation of the Rules

1.4.1 The interpretation of the Rules is the sole responsibility, and at the sole discretion, of LR. Any uncertainty in the meaning of the Rules is to be referred to LR for clarification.

1.5 Client's responsibilities

1.5.1 It is the responsibility and the duty of the builder/main contractor to enable the Surveyors to satisfy themselves that the materials, workmanship and arrangements comply with the classification requirements by arranging for the Surveyors to be present at appropriate stages during the work and for presenting the items to be surveyed in such a way that the Surveyors are readily able to establish that all component/sub-component items have been manufactured, assembled, and tested in accordance with the appropriate requirements.

1.5.2 It is the responsibility of the Owners/operators, designer, builder and the installer to familiarize themselves with the appropriate sections of the Rules.

1.5.3 Survey procedures undertaken by LR when providing services are on the basis of periodical visits involving both monitoring and direct survey. However, LR's Surveyors will not be in continual attendance. Since construction and installation are continuous processes, the builder has the overall responsibility to ensure and document that the requirements of the Rules, approved drawings and any amendments agreed by the attending LR Surveyors have been complied with.

■ Section 2 Withdrawal/Suspension of class

2.1 Withdrawal of class

2.1.1 When the class of a linkspan is withdrawn by the Committee in consequence of a request from the operators, the notation 'Class withdrawn at operator's request' (with date) will be assigned.

2.2 Suspension of class

2.2.1 When the Regulations for surveys on the structural components, equipment or engineering systems, as appropriate, have not been complied with and the linkspan is thereby not entitled to retain class, the class will be suspended, at the discretion of the Committee, and a corresponding notation will be assigned.

2.2.2 Class will be automatically suspended and the Certificate of Class will become invalid if the Annual or Intermediate Survey is not completed within three months of the due date of the survey.

2.2.3 Class will be automatically suspended from the expiry date of the Certificate of Class in the event that the Special Survey has not been completed by the due date and an extension has not been agreed (see 4.5.8 and 4.5.10), or that the facility is not under attendance by the Surveyors with a view to completion of the survey prior to resuming operation.

2.2.4 When in accordance with 4.6.3 a condition of class is imposed, a due date will be assigned for completion and the linkspan's class will be subject to a suspension procedure if the condition of class is not dealt with satisfactorily, or postponed by agreement, by the due date.

2.2.5 When it is found, from the reported condition of the structural components, equipment or machinery of a linkspan, that an operator has failed to comply with Regulations 1.1.7, 4.6.1, 4.6.4 or 4.6.5 the class may be suspended by the Committee, and a corresponding notation assigned. When it is considered that an operator's failure to comply with these requirements is sufficiently serious the suspension of class may be extended to include other linkspans controlled by the same operators, at the discretion of the Committee.

2.2.6 When it is found that a linkspan is being operated in a manner contrary to that agreed at the time of classification, i.e. outwith the approved design loadings and environmental conditions, the class may be suspended.

2.3 Recording Withdrawal/Suspension of class

2.3.1 In all instances of class withdrawal or suspension, the withdrawn or suspended class notation, with date of application, will appear in the *Maritime Guide*. In cases where class has been suspended by the Committee and it becomes apparent that the operators no longer intend to retain LR's class, the notation will be amended to withdrawn status. After class withdrawn status has been established in the *Maritime Guide* for one year, it will be automatically amended to 'classed LR until' (with date).

Classification Regulations

Part 1, Chapter 2

Sections 3 & 4

■ Section 3 Class characters and notations

3.1 General

3.1.1 This Section details the character symbols and notations which comprise the class assigned to linkspans.

3.1.2 The operational design conditions assigned to linkspans built and classed in accordance with the Rules will be issued as an appendix to the Classification Certificate and are to appear in the Operational Manual of the linkspan where such a Manual is required by the Rules.

3.2 Character symbols

3.2.1 All linkspans when classed, will be assigned a character of classification comprising one or more character symbols as applicable, e.g. **AT**.

3.2.2 A full list of character symbols for which craft may be eligible is as follows:

- AT** Signifies the linkspan has been constructed under LR's Special Survey and found to be in compliance with the Rules to the satisfaction of the Committee.
- A** Signifies the linkspan has been found to have been built in accordance with LR's Rules and maintained in accordance with the Rules.
- T** Signifies mooring or tethering equipment has been approved by LR as having been found in accordance with the Rules.

3.3 Class notations

3.3.1 In general, linkspans complying with the requirements of the Rules will be eligible for one of the following appropriate class notations:

- AT** Passenger Linkspan for service at.....'
- AT** Vehicle Linkspan for service at.....'
- AT** Passenger and Vehicle Linkspan for service at.....'

or for non-buoyant linkspans:

- A** Passenger Linkspan for service at.....'
- A** Vehicle Linkspan for service at.....'
- A** Passenger and Vehicle Linkspan for service at.....'

3.4 Other notations

3.4.1 ***IWS**. This notation (In-water Survey) may be assigned to a linkspan which has its underwater surfaces coated with an approved high resistant paint with a view to foregoing specific dry-docking survey requirements and where the applicable requirements of LR's Rules are complied with (see Ch 3,3.3).

3.5 Descriptive note

3.5.1 In addition to any class notations, an appropriate descriptive note may be entered in column six of the *Maritime Guide* indicating the type of linkspan in greater detail than is contained in the class notation, and/or providing additional information about the linkspan's design and construction. This descriptive note is not an LR classification notation and is provided solely for the information of users of the *Maritime Guide*.

■ Section 4 Surveys and certificates

4.1 Statutory surveys

4.1.1 LR will act, when authorized on behalf of Governments and requested to do so by Owners/operators, in respect of National and International statutory safety and other requirements.

4.2 New construction surveys

4.2.1 When it is intended to build a linkspan for classification with LR, application should be made to LR in writing. Constructional plans and all necessary particulars relevant to the structural aspects, equipment and machinery, where applicable, and as detailed in the Rules, are to be submitted before the work is commenced. Any proposals for subsequent modifications or additions to the scantlings, arrangements or equipment are to be submitted for approval before work commences.

4.2.2 Where the proposed design of a linkspan embodies the use of either materials or principles of structural arrangement (or of construction) which are without established successful precedent to an extent that the short and/or long term performance of the design cannot, in the opinion of LR, be predicted with confidence by conventional analytical methods, then special tests (which may include model tests) and/or examinations either before the commissioning of and/or during the early service life of the linkspan may be required. In such cases a suitable notation may be entered in the *Maritime Guide*.

4.2.3 The materials used in the construction of the linkspan and machinery intended for classification are to comply with the requirements of the *Rules for the Manufacture, Testing and Certification of Materials*.

4.2.4 The Surveyor is to be satisfied that the capability, organizational systems and facilities of the builder and any sub-contractors are such that acceptable standards can be obtained both for the construction of the linkspan and the installation of machinery, hydraulic, electrical and control equipment.

Classification Regulations

Part 1, Chapter 2

Section 4

4.2.5 New linkspans intended for classification are to be built and installed under LR's Special Survey. The Surveyors are to be satisfied that the materials, workmanship and arrangements at the locations of component manufacture and installation are in accordance with the Rules. Any items not in accordance with the Rules or the approved plans are to be brought to the attention of the attending Surveyors and rectified to their satisfaction.

4.2.6 For compliance with 4.2.5, LR is prepared to consider methods of survey and inspection for construction which formally include partial reliance on defined procedures relating to the builder's management, organization and quality systems and thereby to those of the component manufacturers.

4.2.7 Copies of approved plans (showing the linkspan as built), essential certificates and records are to be made readily available for use when required by LR's Surveyors.

4.2.8 At key stages during component manufacture and installation, to be agreed with the builders, or their sub-contractors as appropriate, the linkspan is to be examined by the LR Surveyor and upon completion of installation the linkspan is to be examined by the LR Surveyor and tested as specified in the Rules.

4.2.9 All control equipment essential for the operation and/or safety of the linkspan is to be arranged, installed and tested in accordance with the Rules, as applicable.

4.2.10 The date of completion of the Special Survey during construction of linkspans built under LR's inspection will normally be taken as the date of build to be entered in the *Maritime Guide*. If the period between fabrication at the builders and completion of installation at the site is, for any reason, unduly prolonged, the dates of fabrication and completion of installation at the site may be separately indicated in the *Maritime Guide*.

4.2.11 A linkspan which is not put into commission within six months of completion may be re-examined before being put into service. If the condition is then found to be satisfactory, subsequent surveys will date from the time of such examination.

4.3 The first classification of existing linkspans not built under survey

4.3.1 When classification is desired for a linkspan not built under the supervision of LR's Surveyors, application should be made to LR in writing.

4.3.2 Information as detailed in Pt 3, Ch 1,8 is to be submitted. If plans cannot be obtained or prepared by the operators, facilities are to be given for LR's Surveyors to obtain the necessary information from the linkspan.

4.3.3 Plans of the following items, where fitted, (plans of piping are to be diagrammatic) together with the particulars of the materials used in the construction of the air receivers and important forgings are to be submitted:

- General pumping arrangements, including air and sounding pipes.
- Bilge and ballast pumping arrangements in the machinery space, including the capacities of the pumps on bilge service.
- Air receivers.
- Electrical circuits.
- Arrangement of compressed air systems.
- Arrangement of hydraulic systems.
- Ventilation arrangements of all enclosed spaces which require access.
- Remote and/or automatic controls for operating machinery.

4.3.4 Plans additional to those detailed in 4.3.3 need not be submitted unless the machinery is of a novel or special character affecting classification.

4.3.5 The survey requirements for linkspans which have not been built under LR's Survey are indicated in Ch 3,8.

4.3.6 In the case of linkspans over 15 years of age, the requirements for classification of linkspans not built under survey will be specially considered.

4.4 Reclassification of existing linkspans

4.4.1 When reclassification or class reinstatement is desired for a linkspan for which the class previously assigned by LR has been withdrawn or suspended, the Committee will direct that a survey, appropriate to the age of the linkspan and the circumstances of the case, be carried out by LR's Surveyors. If, at such survey, the linkspan is found to be in accordance with the requirements of the Rules and Regulations, the Committee will be prepared to consider reinstatement of the original class or the assignment of such other class as may be deemed necessary. The date of any reclassification will be recorded in the *Maritime Guide*.

4.4.2 In the case of linkspans over 15 years of age, the requirements for reclassification will be specially considered.

4.4.3 The Committee reserves the right to decline an application for classification or reclassification where the prior history or condition of the linkspan indicates this to be appropriate.

4.5 Existing linkspans – Periodical Surveys

4.5.1 Linkspans are to be subjected to the periodical survey requirements as defined in Chapter 3.

4.5.2 Annual Surveys are to be held on all linkspans within three months, before or after each anniversary of the completion, commissioning or Special Survey.

Classification Regulations

Part 1, Chapter 2

Section 4

4.5.3 Docking or In-water Surveys are to be held on all floating or submerged elements of linkspans twice in a five year period and the maximum interval between successive surveys is not to exceed three years, and one of the two surveys required in a five year period should coincide with the Special Survey. Consideration may be given at the discretion of the Committee to any special circumstances justifying an extension of this interval.

4.5.4 Intermediate Surveys are to be held on all linkspans instead of the second or third Annual Survey after completion, commissioning or Special Survey.

4.5.5 The interval between Docking or In-water Surveys for linkspans operating in fresh water may, at the discretion of the Committee, be greater than that given in 4.5.3.

4.5.6 Attention is to be given by the operators to any relevant statutory requirements of the National Authority of the country in which the linkspan is sited.

4.5.7 Survey requirements for Docking or In-water Surveys are given in Ch 3,3 as appropriate.

4.5.8 All linkspans classed with LR are also to be subjected to Special Surveys. The Surveys become due at five-yearly intervals, the first periodical Special Survey five years from the date of the first Special Survey during construction or date of the first Special Survey for Classification, and thereafter five years from the date for the previous Special Survey. Consideration can be given at the discretion of the Committee to any exceptional circumstances justifying an extension of the linkspan classification to a maximum of three months beyond the fifth year. If an extension is agreed, the next period of classification will start from the due date of the Special Survey before the extension was granted.

4.5.9 Special Surveys may be commenced at the fourth Annual Survey or fourth anniversary, as appropriate, after completion, commissioning or previous Special Survey, and be progressed during the succeeding year with a view to completion by the due date of the Special Survey.

4.5.10 Special Surveys which are commenced prior to their due date are not to extend over a period greater than 12 months, except with the prior approval of the Committee.

4.5.11 Linkspans which have satisfactorily passed a Special Survey will have a record entered in the *Maritime Guide* indicating the date. Where the Special Survey is completed more than three months before the due date, the new record of Special Survey will be the final date of survey. In all other cases the date recorded will be the fifth anniversary.

4.5.12 Complete Surveys of machinery become due at five yearly intervals, the first one five years from the date of build or date of first classification as recorded in the *Maritime Guide*, and thereafter five years from the date recorded in the *Maritime Guide* for the previous Complete Survey. Consideration can be given at the discretion of the Committee to any exceptional circumstances justifying an extension to a maximum of three months beyond the fifth

year. If an extension is agreed to, the next period of machinery class will start from the due date of Complete Survey of machinery before extension was granted. Surveys which are commenced prior to their due date are not to extend over a period greater than 12 months, except with the prior approval of the Committee. On satisfactory completion of a Survey, an appropriate record will be made in the *Maritime Guide*. Where the Complete Survey is completed more than three months before the due date, the new date recorded will be the final date of survey. In all other cases the date recorded will be the fifth anniversary.

4.5.13 If it is found desirable that any part of the machinery should be examined again before the due date of the next survey, a certificate for a limited period will be granted in accordance with the nature of the case.

4.5.14 Linkspans covered by 4.2.2 may be subject to additional survey requirements. Such survey requirements will be detailed at the assignment of classification.

4.6 Damages, repairs and alterations

4.6.1 All repairs to the structure, equipment and machinery which may be required in order that a linkspan may retain class, (see 1.1.7), are to be carried out to the satisfaction of LR's Surveyors.

4.6.2 When at any survey the Surveyors consider repairs to be immediately necessary, either as a result of damage, or wear and tear, they are to communicate their recommendations at once to the operators, or their representative. When such recommendations are not complied with, immediate notification is to be given by the Surveyors to the Committee so that the class status of the installation may be considered.

4.6.3 When at any survey it is found that any damage, defect or breakdown (see 1.1.7) is of such a nature that does not require immediate permanent repair, but is sufficiently serious to require rectification by a prescribed date in order to maintain class, a suitable condition of class is to be imposed by the Surveyors and recommended to the Committee for consideration.

4.6.4 If a linkspan is to be moved from the service area under tow or by any other means and the operators wish the linkspan to remain in class, the operators are to advise LR prior to departure.

4.6.5 Plans and particulars of any proposed alterations to the approved scantlings and arrangements of the structure or machinery are to be submitted for approval to LR by the operators or builders or their representatives at the earliest opportunity, prior to the commencement of the alterations and such alterations are to be carried out to the satisfaction of LR's Surveyors.

Classification Regulations

Part 1, Chapter 2

Sections 4 & 5

4.7 Certificates

4.7.1 When the required reports, on completion of the survey of new or existing linkspans which have been submitted for classification, have been received from the Surveyors and approved by the Committee, a Certificate of First Entry of Classification, signed by the Chairman, or the Deputy Chairman and Chairman of the Sub-Committee of Classification, will be issued to the Owners/operators.

4.7.2 A Certificate of Class valid for five years subject to endorsement for Annual and Intermediate Surveys, as appropriate, will also be issued to the operators after the satisfactory completion of each special survey.

4.7.3 LR's Surveyors are permitted to issue provisional (interim) certificates to enable a linkspan classed with LR to enter or continue in service provided that in their opinion it complies with the Rules. Such certificates will embody the Surveyors' recommendations for continuance of class, but all such certificates are subject to confirmation by the Committee.

4.8 Notice of surveys

4.8.1 It is the responsibility of the operators to ensure that all surveys necessary for the maintenance of class are carried out at the proper time and in accordance with the instructions of the Committee.

4.8.2 LR will give timely written notice to operators about forthcoming surveys. The omission of such notice, however does not absolve the operators from their responsibility to comply with LR's survey requirements for maintenance of class.

4.9 Survey of linkspans out of commission

4.9.1 Surveys for continuation of class may be required at the discretion of the Committee.

4.10 Appeal from Surveyors' recommendations

4.10.1 If the recommendations of LR's Surveyors are considered in any case to be unnecessary or unreasonable, appeal may be made to the Committee, who may direct a Special Examination to be held.

■ Section 5 IACS QSCS Audits

5.1 Audit of surveys

5.1.1 The surveys required by the Regulations may be subject to audit in accordance with the requirements of the International Association of Classification Societies Quality System Certification Scheme.

Periodical Survey Regulations

Part 1, Chapter 3

Sections 1 & 2

Section

- 1 **General**
- 2 **Annual Surveys – Structural and machinery**
- 3 **Docking Surveys and In-water Surveys – Structural and machinery requirements**
- 4 **Intermediate Surveys – Structural and machinery requirements**
- 5 **Special Survey – Structural requirements**
- 6 **Machinery surveys – General requirements**
- 7 **Electrical equipment surveys**
- 8 **Initial classification of linkspans not built under survey**

■ Section 1 General

1.1 Frequency of surveys

1.1.1 The requirements of this Chapter are applicable to the Periodical Surveys set out in Ch 2,4.5. Except as amended at the discretion of the Committee, the periods between such surveys are as follows:

- (a) Annual Surveys, as required by Ch 2,4.5.2.
- (b) Docking and In-water Surveys as required by Ch 2,4.5.3.
- (c) Intermediate Surveys as required by Ch 2,4.5.4.
- (d) Special Surveys at five-yearly intervals, see Ch 2,4.5.8.
- (e) Complete Surveys of machinery at five-yearly intervals, see Ch 2,4.5.12.

1.2 Surveys for damage or alterations

1.2.1 At any time when a linkspan is undergoing alterations or damage repairs, any exposed parts of the structure normally difficult to access are to be specially examined, e.g. if any part of the auxiliary machinery, insulation or fittings, is removed for any reason, the steel structure in way is to be carefully examined by the Surveyor, or when cement based screed in the bottom or covering on decks and/or ramps is removed, the plating in way is to be examined before the cement or covering is re-laid.

1.3 Unscheduled surveys

1.3.1 In the event that LR has cause to believe that its Rules are not being complied with, LR reserves the right to perform an unscheduled survey of the linkspan.

1.3.2 In the event of significant damage or defect affecting any linkspan, LR reserves the right to perform unscheduled surveys of the structure or machinery of any other similar linkspans classed by LR and deemed to be vulnerable.

1.4 Definitions

1.4.1 **A Ballast Tank** is a tank which is used primarily for salt-water, fresh water or permanent ballast.

1.4.2 **Spaces** are separate compartments such as holds and tanks.

1.4.3 **Representative Spaces** are those which may be expected to reflect the condition of other spaces of similar type and service and with similar corrosion prevention systems.

1.4.4 **Critical Areas** are locations vulnerable to substantial corrosion, buckling and/or fatigue cracking, and single critical joints.

1.4.5 **Substantial Corrosion** is wastage of individual plates and stiffeners in excess of 75 per cent of allowable margins, but within acceptable limits.

1.4.6 **Protective Coatings** are to be hard coatings and are to be applied and maintained in compliance with the manufacturer's specification.

1.4.7 **Coating condition** of a specific area is defined as follows:

GOOD: minor spot rusting affecting not more than 20 per cent of the area.

FAIR: local breakdown at edges of stiffeners and weld connections and/or light rusting affecting 20 per cent or more of the area.

POOR: general breakdown of coating affecting 20 per cent or more of the area or hard scale affecting 10 per cent or more of the area.

■ Section 2 Annual Surveys – Structural and machinery

2.1 General

2.1.1 Whenever practicable, Annual Surveys are to be held concurrently with statutory annual or other relevant statutory surveys, where these exist.

2.1.2 At Annual Surveys, the Surveyor is to examine the linkspan so far as necessary and practicable, in order to be satisfied as to its general condition. All critical areas are to be opened up for close examination as directed by the Surveyor, see 2.2.5.

Periodical Survey Regulations

Part 1, Chapter 3

Sections 2 & 3

2.2 Annual Surveys

2.2.1 The Surveyor is to confirm that the linkspan is operated at the specified location or within the general port area, as applicable, as defined by the class notation, for which it is currently approved.

2.2.2 The operators are to confirm to the Surveyor that vessels utilizing the linkspan do not exceed the maximum displacement or berthing speed and approach angles specified in the current approval. Operators are to provide evidence that the maximum displacement and approach speeds/angles have been communicated to the users of the installation.

2.2.3 The mooring or tethering arrangements are to be examined, as far as practicable, for all linkspans that have been assigned the class character symbol **T**.

2.2.4 The Surveyor is to confirm that, where provided, fendering arrangements continue to remain efficient.

2.2.5 In addition to the applicable requirements of 2.2.1 to 2.2.4, the following are to be dealt with, where applicable:

- (a) Examination of pontoon or other supporting structure, including internal bulkheads and watertight doors as applicable.
- (b) Examination of bridges, ramps and walkways structures including end flaps and slides.
- (c) Examination of vehicle running surfaces.
- (d) Examination of bridges, ramps and walkways hinge arrangements, pivot pins and slewing bearings including bankseat bearings, and any flap hinge arrangements.
- (e) Examination of sheaves, sprockets, guide rollers, axle pins and bearings forming a part of any ramp lifting arrangement.
- (f) Examination of winches, hydraulic cylinders and attachments forming a part of any ramp lifting arrangement.
- (g) Examination of operating locks, stowage locks, and safety guards including any associated hydraulic systems.
- (h) Examination of wire ropes forming a part of any ramp lifting arrangement.
- (j) Examination of chains forming a part of any ramp lifting arrangement.
- (k) Examination of shackles and links forming a part of any ramp lifting arrangement.
- (l) Examination of rope drums forming a part of any ramp lifting arrangement including the rope attachment to them.
- (m) Examination of mooring arm structures, hinge arrangements, link pins and pontoon or quay mounted supporting structure.
- (n) Verification by operational test of the efficient safe working of lifting appliances and hydraulic systems.
- (o) Verification by operational test of any passenger and/or vehicle control barriers at access points to the linkspan.
- (p) Verification by operational test of the pumps and piping systems for bilge and ballast arrangements. The piping systems and associated valves are to be examined as far as is practicable.

- (q) Examination of air venting and sounding arrangements for all tanks.
- (r) The condition of the electrical equipment and cabling is to be examined under operating conditions so far as is practicable.

Section 3 Docking Surveys and In-water Surveys – Structural and machinery requirements

3.1 General

3.1.1 At Docking Surveys or In-water Surveys the Surveyor is to examine the linkspan and auxiliary machinery, where fitted, so far as necessary and practicable, in order to be satisfied as to the general condition. See also Section 6.

3.1.2 The requirements of this Section are not applicable to any linkspan which derives its inherent primary support from non-buoyant means only.

3.2 Docking Surveys

3.2.1 Where a linkspan is in dry-dock or on a slipway it is to be placed on blocks of sufficient height, and proper staging is to be erected as may be necessary, for the examination of the shell including bottom plating.

3.2.2 Attention is to be given to those parts of the structure particularly liable to excessive corrosion or to deterioration from causes such as chafing and lying on the ground or sea-bed and to any undue unfairness of the plating of the bottom.

3.2.3 The sea connections and overboard discharge valves, where fitted, and their attachments to the pontoon and the gratings at the sea inlets are to be examined.

3.2.4 Where provided, chain cables are to be ranged, and examined by the Surveyor (see also 5.3.9 and Table 3.5.1).

3.3 In-water Surveys

3.3.1 An In-water Survey is to provide the information normally obtained from the Docking Survey, so far as is practicable.

3.3.2 Proposals for In-water Surveys are to be submitted in advance of the survey being required so that satisfactory arrangements can be agreed with LR.

Periodical Survey Regulations

Part 1, Chapter 3

Sections 3 & 4

3.3.3 The In-water Survey is to be carried out under the surveillance of an LR Surveyor, with the linkspan at a suitable draught in sheltered waters; the in-water visibility is to be good and the structure below the waterline is to be clean. The Surveyor is to be satisfied that the method of pictorial presentation is satisfactory. There is to be good two-way communication between the Surveyor and the diver.

3.3.4 Diving and In-water Survey operations are to be carried out by firms recognized by LR. Continued recognition by LR will be dependent on the standard of workmanship by the firm being maintained to the satisfaction of LR's Surveyors.

3.3.5 If the In-water Survey reveals damage or deterioration that requires early attention, the Surveyor may require that the linkspan be dry-docked in order that a more thorough survey can be undertaken and the necessary remedial work carried out.

3.3.6 Where a linkspan has an ***IWS** notation, the condition of high resistant paint is to be confirmed in order that the ***IWS** notation can be maintained.

3.3.7 Some National Administrations may have requirements additional to those of 3.3.1 to 3.3.6.

3.3.8 For linkspans where In-water Surveys are carried out the following are to be dealt with:

- (a) The requirements for In-water Surveys are to be carried out as far as practicable taking due account of any limitations due to reduced access or visibility at the specified service location.
- (b) The condition of the high resistant paint is to be confirmed. The Surveyor may require the linkspan to be dry-docked for maintenance of the high resistant paint coating of the underwater portion of the hull where any deterioration is found.
- (c) A survey of all salt-water ballast and buoyancy tanks is required. Where protective coatings are found to be in GOOD condition as defined in 1.4.7 the extent of the survey may be specially considered. The internal surfaces of the underwater portion of the shell plating are to be examined.
- (d) The condition of protective coatings in all salt-water ballast and buoyancy tanks is to be confirmed. Where a protective coating is found to be in POOR condition as defined in 1.4.7 and it has not been repaired, or where a protective coating was not applied from the time of construction, maintenance of class will be subject to the spaces in question being internally examined and gauged as necessary at Annual Surveys.
- (e) The mooring or tethering arrangements are to be examined for all linkspans that have been assigned the class character symbol **T**. Where mooring and tethering arrangements are confined to above water structures and fittings, an examination is also to be carried out of any shore mounted structures, including any bankseat bearings which form an inherent part of these arrangements. Where mooring and tethering arrangements include guidepiles and yokes, the yokes are to be examined. The Surveyor may require under-

water mooring ropes or chains to be lifted in order to ascertain their condition by opening out or gauging as appropriate.

■ Section 4 Intermediate Surveys – Structural and machinery requirements

4.1 General

4.1.1 Whenever practicable, Intermediate Surveys are to be held concurrently with statutory annual or other relevant statutory surveys, where these exist.

4.2 Intermediate Surveys

4.2.1 The requirements of Section 2 are to be complied with where appropriate.

4.2.2 A General Examination of salt-water ballast and buoyancy tanks is to be carried out as required by 4.2.4 and 4.2.5. If such examinations reveal no visible structural defects then the examination may be limited to a verification that the protective coating remains in GOOD or FAIR condition as defined in 1.4.7. When considered necessary by the Surveyor thickness measurement of the structure is to be carried out.

4.2.3 For salt-water ballast and buoyancy tanks, where a protective coating is found to be in POOR condition, as defined in 1.4.7, where a soft coating has been applied or where no protective coating has been applied from the time of construction, maintenance of class will be subject to the spaces in question being internally examined and gauged as necessary at Annual Surveys.

4.2.4 For all linkspans over five years of age and up to 10 years of age, representative salt-water ballast and buoyancy tanks are to be examined. For tanks, where a protective coating is found in POOR condition, as defined in 1.4.7, or other defects are found, where a soft coating has been applied or where a protective coating was not applied from the time of construction, the examination is to be extended to other ballast tanks of the same type.

4.2.5 For all linkspans over 10 years of age, all salt-water ballast and buoyancy tanks are to be examined.

4.2.6 The Surveyor is to carry out a survey and thickness measurements of any structure identified at the previous Special Survey as having substantial corrosion.

Periodical Survey Regulations

Part 1, Chapter 3

Section 5

Section 5 Special Survey – Structural requirements

5.1 General

5.1.1 The survey is to be of sufficient extent to ensure that the linkspan and related piping, where appropriate, is in satisfactory condition, subject to proper maintenance and operation and to periodical surveys being carried out as required by the Regulations.

5.1.2 The requirements of Section 2 are to be complied with as applicable for all linkspans.

5.1.3 A Docking or In-water Survey in accordance with the requirements of Section 3 is to be carried out as part of the Special Survey.

5.2 Preparation

5.2.1 The linkspan is to be prepared for overall survey in accordance with the requirements of Table 3.5.1, where appropriate. The preparation should be of sufficient extent to permit as clear a view as reasonably practicable of corrosion, fractures, or other damages apparent on visual examination.

5.3 Examination and testing

5.3.1 All spaces within the linkspan are to be examined where appropriate.

5.3.2 In certain circumstances the internal examination of fresh water and hydraulic/oil tanks, where appropriate, may be waived. For the minimum extent of tank internal examination, see Table 3.5.2.

5.3.3 For salt-water ballast and buoyancy tanks, where a protective coating is found in POOR condition as defined in 1.4.7 and it is not renewed, where a soft coating has been applied or where no protective coating has been applied from the time of construction, maintenance of class will be subject to the space in question being internally examined and gauged as necessary at Annual Surveys.

5.3.4 All tanks are to be tested by a head sufficient to give the maximum pressure that can be experienced in service. Tanks may be tested afloat provided that their internal examination is also carried out afloat.

5.3.5 Where repairs are effected to the shell plating or bulkheads, any tanks in way are to be tested to the Surveyor's satisfaction on completion of these repairs.

5.3.6 In cases where the inner surface of the bottom plating is covered with cement, asphalt, or other composition, the removal of this covering may be dispensed with, provided that it is inspected, tested by beating or chipping, and found sound and adhering satisfactorily to the steel.

5.3.7 All decks and/or ramps, bridges, walkways and associated fittings, casings and superstructures are to be examined.

5.3.8 Wood decks or sheathing, if fitted, are to be examined; if decay or rot is found or the wood is excessively worn the wood is to be renewed. When a wood deck, laid on stringers and ties, has worn by 20 per cent or more, it is to be renewed. Attention is to be given to the condition of the plating under wood decks, sheathing or other deck and/or ramp covering. If it is found that such coverings are broken, or are not adhering closely to the plating, sections are to be removed as necessary to ascertain the condition of the plating. (See also 1.2.1).

Table 3.5.1 Survey preparation

Periodical Special Survey I and II (Linkspans up to 10 years old)	Periodical Special Survey III and subsequent (Linkspans 15 years old and over)
<p>(1) All spaces are to be cleared and cleaned as necessary to allow proper examination. Suitable access platforms etc., are to be provided as required. Where necessary, lining and pipe casings are to be removed for examination</p> <p>(2) The steelwork is to be exposed and cleaned and rust removed as may be required for its proper examination by the Surveyor</p> <p>(3) All tanks are to be cleaned as necessary to permit examination, where this is required by Table 3.5.2</p> <p>(4) Casings or covers of air, sounding and other pipes and linings in way of shell penetrations are to be removed, as required by the Surveyor</p> <p>(5) Bearings, sheaves, sprockets, guide rollers, axle pins, pintles and hinges are to be opened up as required by the Surveyor</p> <p>(6) At Special Survey II the chain locker, where provided, is to be cleaned internally for examination. The chain cables and/or other tethering components are to be ranged for inspection</p>	<p>In addition to the requirements for Special Survey II, the following are to be complied with:</p> <p>(1) Portions of wood sheathing, or other covering on steel decks and/or ramps are to be removed, as considered necessary by the Surveyor, in order to ascertain the condition of the plating</p>

Periodical Survey Regulations

Part 1, Chapter 3

Section 5

Table 3.5.2 Tank internal examination requirements

Tank	Periodical Special Survey I (Linkspans 5 years old)	Periodical Special Survey II (Linkspans 10 years old)	Periodical Special Survey III (Linkspans 15 years old)	Periodical Special Survey IV (Linkspans 20 years old)	All subsequent Periodical Special Surveys
Salt water ballast tanks	All tanks	All tanks	All tanks	All tanks	All tanks
Fresh water	None	See Note 1	See Note 2	See Note 3	All tanks
Hydraulic oil/oil tanks where fitted	None	See Note 1	See Note 2	See Note 3	All tanks
NOTES 1. Tanks used exclusively for fresh water ballast, or hydraulic oil or other oil need not all be examined internally provided that the Surveyor is satisfied with the condition, after both external examination and testing and from an internal examination of the after end of one forward tank, and one selected deep tank. 2. Tanks used exclusively for fresh water ballast, or hydraulic oil or other oil, need not all be examined internally provided that the Surveyor is satisfied with the condition, after both external examination and testing and from an internal examination of one forward tank, one aft and one deep tank. 3. Tanks used exclusively for fresh water ballast, or hydraulic oil or other oil, need not all be examined internally provided that the Surveyor is satisfied with the condition, after both external examination and testing and from internal examination of at least one tank amidships, one forward, one aft and one deep tank.					

Table 3.5.3 Thickness measurement

Periodical Special Survey I (Linkspans 5 years old)	Periodical Special Survey II (Linkspans 10 years old)	Periodical Special Survey III and subsequent (Linkspans 15 years old and over)
(1) Critical areas, as required by the Surveyor	(1) Critical areas, as required by the Surveyor	(1) Selected areas of ramp, bridges, walkways and superstructure plating (2) Wind and water strakes throughout (3) Side shell plating and frames in way of ballast tanks (4) Other critical areas, as required by the Surveyor

5.3.9 Where provided, the mooring and tethering systems are to be examined. If any length of chain cable is found to be reduced in mean diameter at its most worn part by 12 per cent or more from its nominal diameter, it is to be renewed.

5.3.10 Watertight doors, air and sounding pipes, as appropriate, are to be examined and operationally tested as applicable.

5.4 Thickness measurement

5.4.1 The Surveyor may require to measure the thickness of the material in any portion of the structure where signs of wastage are evident or wastage is normally found. Any parts of the structure which are found defective or excessively reduced in scantlings are to be made good by materials of the approved scantlings and quality. Attention is to be given to the structure in way of discontinuities.

5.4.2 The minimum requirements for thickness measurement are given in Table 3.5.3.

5.4.3 Thickness measurements are normally to be by means of ultrasonic test equipment and are to be carried out by a firm qualified as Grade 1 or Grade 2 according to Lloyd's Register *Approval for Thickness Measurement of Hull Structures*.

5.4.4 The degree of supervision or check testing by the Surveyor is dependent upon the grade of approval extended to the firm carrying out the thickness measurements:

- The work of firms having Grade 1 approval is subject to check testing by the Surveyor.
- Thickness measurements by firms having Grade 2 approval is to be carried out with the Surveyor substantially in attendance.

5.4.5 Thickness measurements may be carried out in association with the fourth Annual Survey.

5.4.6 The Surveyor may extend the scope of thickness measurement if deemed necessary.

5.5 Thickness measurement reporting

5.5.1 A report is to be prepared by the approved firm carrying out the thickness measurement. The report is to give the location of measurement, the thickness measured as well as the corresponding original thickness. The report is to give the date when the measurement was carried out, the type of measuring equipment, names of personnel and their qualifications and is to be signed by the operator and supervisor.

Periodical Survey Regulations

Part 1, Chapter 3

Sections 5, 6 & 7

5.5.2 The thickness measurement report is to be verified and signed by the Surveyor.

■ Section 6 Machinery surveys – General requirements

6.1 Annual, Intermediate and Docking Surveys and In-water Surveys

6.1.1 The requirements of Sections 2, 3 and 4 are to be complied with as applicable.

6.2 Complete Surveys

6.2.1 Provision is to be made for the capability to blank off temporarily all sea openings. At Complete Surveys, all openings to the sea are to be examined together with any valves, cocks and fastenings connected with them.

6.2.2 Where installed, the following machinery and components are also to be examined:

- (a) Engines, air compressors with their intercoolers, filters and/or oil separators and safety devices, and all pumps and components used for operational services.
- (b) Winches and associated lifting equipment, where fitted.

6.2.3 All air receivers for operational services, where fitted, together with their mountings, valves and safety devices, are to be cleaned internally and examined internally and externally. If internal examination of the air receivers is not practicable, they are to be tested hydraulically to 1,3 times the working pressure.

6.2.4 The valves, cocks and strainers of the bilge systems, where fitted, are to be opened up as considered necessary by the Surveyor and together with pipes, are to be examined and tested under working conditions. All safety devices for the foregoing items are to be examined as appropriate.

6.2.5 Hydraulic oil connections, together with all filters, used for operational services are to be opened up and examined or tested, as considered necessary by the Surveyor. All safety devices for the foregoing items are to be examined as appropriate.

6.2.6 Ballast connections, together with all filters, used for operational services are to be opened up and examined or tested, as considered necessary by the Surveyor. All safety items for the foregoing items are to be examined as appropriate.

6.2.7 All controls and alarms fitted which are essential for the operation and/or safety of the linkspan are to be tested to demonstrate that they are in good working order.

■ Section 7 Electrical equipment surveys

7.1 Annual and Intermediate Surveys

7.1.1 The requirements of 2.2 and 4.2 are to be complied with as far as applicable.

7.2 Complete Surveys

7.2.1 An electrical insulation resistance test is to be made on the electrical equipment and cables. The installation may be sub-divided or equipment, which may be damaged, disconnected for the purpose of this test.

7.2.2 The fittings on the main switchboard, section boards and distribution boards, where fitted, are to be examined and over-current protective devices and fuses inspected to verify that they provide suitable protection for their respective circuits.

7.2.3 Circuit-breakers, where fitted, are to be tested, so far as is practicable, to verify that protective devices including preference tripping relays, if fitted, operate satisfactorily.

7.2.4 The electric cables, where fitted, are to be examined, so far as is practicable, without undue disturbance of fixtures or casings unless opening up is considered necessary as a result of observation or of the tests required by 7.2.1.

7.2.5 Navigation light indicators, where fitted, are to be tested under working conditions, and correct operation on the failure of supply or failure of navigation lights verified.

7.2.6 A General Examination of the electrical equipment, as appropriate, in areas which may contain flammable gas or vapour and/or combustible dust is to be made to ensure that the integrity of the safe type electrical equipment has not been impaired owing to corrosion, missing bolts, etc., and that there is not an excessive build-up of dust on or in dust protected electrical equipment. Cable runs are to be examined for sheath and armouring defects, where practicable, and to ensure that the means of supporting the cables are in good order. Tests are to be carried out to demonstrate the effectiveness of bonding straps for the control of static electricity. Alarms and interlocks associated with pressurized equipment or spaces are to be tested for correct operation.

■ **Section 8**
**Initial classification of linkspans
not built under survey**

8.1 General

8.1.1 Periodical Surveys of such a linkspan, when classed, are subsequently to be held as in the case of linkspans built under survey.

8.2 Structure

8.2.1 In all cases the full requirements of Sections 5, 6, and 7 are to be carried out as applicable. Linkspans of recent construction will receive special consideration.

8.2.2 During the survey, the Surveyors are to satisfy themselves regarding the workmanship and verify the approved scantlings and arrangements. For this purpose, and in order to ascertain the amount of any deterioration, parts of the structure will require to be gauged as necessary. Full particulars of the mooring or tethering arrangements are to be submitted, where provided.

8.2.3 When the full survey requirements indicated in 8.2.1 and 8.2.2 cannot be completed at one time, the Committee may consider granting an interim certificate for a limited period. The conditions regarding the completion of the survey will depend on the merits of each particular case, which should be submitted for consideration.

8.3 Machinery

8.3.1 The machinery, hydraulic oil and compressed air pipes are to be examined as required at Complete Surveys. Working pressures are to be determined from the actual scantlings in accordance with the Rules.

8.3.2 The bilge and ballast arrangements are to be examined and amended, as necessary, to comply with the Rules.

8.3.3 The electrical equipment is to be examined as required at Complete Surveys.

8.3.4 The whole of the machinery, including essential controls and alarms, is to be tested under working conditions to the Surveyor's satisfaction.

© Lloyd's Register, 2008
Published by Lloyd's Register
Registered office
71 Fenchurch Street, London, EC3M 4BS
United Kingdom

RULES AND REGULATIONS FOR THE CLASSIFICATION OF LINKSPANS

CONSTRUCTION, DESIGN AND TESTING REQUIREMENTS

JULY 2008

PART 3

Lloyd's
Register

A guide to the Rules

and published requirements

Rules and Regulations for the Classification of Linkspans

Introduction

The Rules are published as a complete set, individual Parts are, however, available on request. A comprehensive List of Contents is placed at the beginning of each Part.

Numbering and Cross-References

A decimal notation system has been adopted throughout. Five sets of digits cover the divisions, i.e. Part, Chapter, Section, sub-Section and paragraph. The textual cross-referencing within the text is as follows, although the right hand digits may be added or omitted depending on the degree of precision required:

- (a) In same Chapter, e.g. see 2.1.3 (i.e. down to paragraph).
- (b) In same Part but different Chapter, e.g. see Ch 3,2.1 (i.e. down to sub-Section).
- (c) In another Part, e.g. see Pt 2, Ch 1,3 (i.e. down to Section).

The cross-referencing for Figures and Tables is as follows:

- (a) In same Chapter, e.g. as shown in Fig 2.3.5 (i.e. Chapter, Section and Figure Number).
- (b) In same Part but different Chapter, e.g. as shown in Fig. 2.3.5 in Chapter 2.
- (c) In another Part, e.g. see Table 2.7.1 in Pt 3, Ch 2.

Rules updating

The Rules are generally published annually and changed through a system of Notices. Subscribers are forwarded copies of such Notices when the Rules change.

Current changes to Rules that appeared in Notices are shown with a black rule alongside the amended paragraph on the left hand side. A solid black rule indicates amendments and a dotted black rule indicates corrigenda.

July 2008

PART	1	REGULATIONS
PART	2	RULES FOR THE MANUFACTURE, TESTING AND CERTIFICATION OF MATERIALS
PART	3	CONSTRUCTION, DESIGN AND TESTING REQUIREMENTS
	Chapter 1	General Conditions and Requirements
	2	Materials
	3	General Structural Design Requirements
	4	Pontoons
	5	Bridge/Vehicle Ramp Strength
	6	Passenger Walkway Strength
	7	Mooring and Tethering Arrangements
	8	Fendering Systems
	9	Appendix for Highway Loads, Section Aerodynamics and Pontoon Drag Coefficients
PART	4	ENGINEERING SYSTEMS

© Lloyd's Register, 2008. All rights reserved.

Except as permitted under current legislation no part of this work may be photocopied, stored in a retrieval system, published, performed in public, adapted, broadcast, transmitted, recorded or reproduced in any form or by any means, without the prior permission of the copyright owner. Enquiries should be addressed to Lloyd's Register of Shipping, 71 Fenchurch Street, London, EC3M 4BS.

CHAPTER	1	GENERAL CONDITIONS AND REQUIREMENTS
Section	1	Application
	1.1	General
	1.2	Exceptions
Section	2	Structural calculations
	2.1	General
Section	3	Equivalents
	3.1	Alternative arrangements and scantlings
Section	4	National Regulations
	4.1	General
Section	5	Inspection and workmanship
	5.1	Inspection
	5.2	Workmanship
Section	6	Acceptance testing of pontoons, bridges, ramps and walkways
	6.1	Pontoons
	6.2	Bridges, ramps and walkways
Section	7	Towage certificate
	7.1	General
Section	8	Information required for approval
	8.1	General
	8.2	Environmental data
	8.3	Operational data
	8.4	Pontoon structural data
	8.5	Vehicle ramps, bridges, walkways and structural steelwork data
	8.6	Mooring and tethering arrangements
	8.7	Other information
CHAPTER	2	MATERIALS
Section	1	Materials of construction
	1.1	General
	1.2	Steel
	1.3	Aluminium
Section	2	Fracture control
	2.1	Grades of steel
Section	3	Corrosion protection
	3.1	General
	3.2	Fabrication primers
	3.3	Internal cathodic protection
	3.4	Aluminium and magnesium anodes
	3.5	External pontoon or steelwork protection
	3.6	Corrosion protection coatings for ballast spaces
CHAPTER	3	GENERAL STRUCTURAL DESIGN REQUIREMENTS
Section	1	General
	1.1	Introduction
	1.2	Pontoons
	1.3	Bridges and vehicle ramps
	1.4	Walkways

Contents

Part 3

Section	2	Structural idealization for pontoons
	2.1	Geometric properties of section
	2.2	Determination of span point
Section	3	Design loading
	3.1	General
	3.2	Hydrostatic loads
	3.3	Dead loads
	3.4	Vehicle loads
	3.5	Walkway loading
	3.6	Wind loading
	3.7	Current loading
	3.8	Wave loading
	3.9	Ship induced loadings
	3.10	Towage loading
	3.11	Snow and ice loading
Section	4	Fatigue assessment
	4.1	General
Section	5	Model tests
	5.1	General
CHAPTER	4	PONTOONS
Section	1	General
	1.1	Application
	1.2	Information required for approval
	1.3	Symbols and definitions
	1.4	Longitudinal or transverse framing
Section	2	Longitudinal strength
	2.1	Design loads
	2.2	Calculation of pontoon section modulus
	2.3	Permissible hull vertical bending and shear stresses
Section	3	Hull envelope plating
	3.1	Bottom shell plating
	3.2	Side and end shell plating
	3.3	Deck plating
Section	4	Hull envelope framing
	4.1	General
	4.2	Longitudinal framing
	4.3	Transverse framing
	4.4	Primary supporting structure
	4.5	Deck beams and longitudinals subject to vehicle loading
	4.6	Deck girders and transverses subject to vehicle loading
	4.7	Direct calculations
	4.8	Ship ramp loads
	4.9	Train decks
	4.10	Heavy or special loads
Section	5	Bulkheads
	5.1	General
	5.2	Number and disposition of bulkheads
	5.3	Watertight and ballast tank bulkheads
	5.4	Corrugated and double plated bulkheads
	5.5	Non-watertight pillar bulkheads
	5.6	Storage of flammable liquid

Contents

Part 3

Section	6	Pillars
	6.1	General
CHAPTER	5	BRIDGE/VEHICLE RAMP STRENGTH
Section	1	General
	1.1	Application
	1.2	Objective
	1.3	Basis of structural design
	1.4	Information required for approval
Section	2	Materials
	2.1	General requirements
Section	3	Design loads and combinations
	3.1	General
	3.2	Basic load factors
	3.3	Forces due to motion of the pontoon or other buoyant support
	3.4	Load combinations
Section	4	Design criteria
	4.1	Allowable stress – Elastic failure
	4.2	Allowable stress – Compression and bending members
	4.3	Allowable stress – Plate buckling failure
	4.4	Allowable stress – Joints and connections
	4.5	Deck plating thickness
	4.6	Deflection criteria
	4.7	Hoisting and slewing arrangements
	4.8	Locking arrangements
	4.9	Safety restraints
	4.10	Deck gradients and transitions
CHAPTER	6	PASSENGER WALKWAY STRENGTH
Section	1	General
	1.1	Application
	1.2	Objective
	1.3	Information required for approval
Section	2	Materials
	2.1	General requirements
Section	3	Design loads and combinations
	3.1	General
	3.2	Basic load factors
	3.3	Forces due to motion of the pontoon or other buoyant support
	3.4	Load combinations
Section	4	Design criteria
	4.1	Allowable stresses
	4.2	Deflection criteria
	4.3	Hoisting and slewing arrangements
	4.4	Safety restraints
CHAPTER	7	MOORING AND TETHERING ARRANGEMENTS
Section	1	General
	1.1	Application
	1.2	Scope
	1.3	Objective

Contents

Part 3

Section	2	Materials
	2.1	Approved manufacturers
	2.2	Tethering arrangements
Section	3	Types of mooring and tethering arrangements
	3.1	Mooring arrangements
	3.2	Tethering arrangements
	3.3	Other types
Section	4	Design loads
	4.1	Environmental loads
	4.2	Operational loads
	4.3	Berthing loads
Section	5	Load combinations
	5.1	General
Section	6	Safety factors and allowable stresses
	6.1	Safety factors
	6.2	Allowable stresses
CHAPTER	8	FENDERING SYSTEMS
Section	1	General
	1.1	Application
Section	2	Design
	2.1	General
CHAPTER	9	APPENDIX FOR HIGHWAY LOADS, SECTION AERODYNAMICS AND PONTOON DRAG COEFFICIENTS
Section	1	Alternative highway live loads based on BS 5400 Part 2 1978 – HA and HB
	1.1	General
	1.2	Type HA loading
	1.3	Type HB loading
	1.4	Derivation and application of HA and HB loading
Section	2	Aerodynamic data
	2.1	Wind force coefficient, C_f
	2.2	Aerodynamic slenderness and section ratio
	2.3	Shielding and solidity factors
	2.4	Tower sections
Section	3	Drag coefficients for pontoons
	3.1	General
	3.2	Wall-sided boxes
	3.3	Pontoons and barges

General Conditions and Requirements

Part 3, Chapter 1

Sections 1, 2 & 3

Section

- 1 **Application**
- 2 **Structural calculations**
- 3 **Equivalents**
- 4 **National Regulations**
- 5 **Inspection and workmanship**
- 6 **Acceptance testing of pontoons, bridges, ramps and walkways**
- 7 **Towage certificate**
- 8 **Information required for approval**

■ Section 1 Application

1.1 General

1.1.1 In general the Rules apply to linkspans as defined in Pt 1, Ch 2, 1.2.1, constructed of steel or aluminium alloys.

1.1.2 Linkspans specifically designed for similar purposes, or constructed in other materials may also be considered based on the general standards of the Rules.

1.2 Exceptions

1.2.1 The Rules cover only those aspects of safety which are explicitly or implicitly embodied in them. They do not cover any other technical or operational characteristics of linkspans, such as the intact and damage stability of pontoons, vibration, towage and the potential for environmental pollution. See also Pt 1, Ch 2, 1.2.1 and 1.3.4 regarding interface components.

■ Section 2 Structural calculations

2.1 General

2.1.1 The Rules embody structural requirements for linkspans and have been developed to enable adequate regulatory evaluation by normal methods of structural analysis on the basis that:

- (a) The wave induced loads and load variations on the structural components are not of an excessive order during normal operations, and:
Should the wave induced loads and load variations (relative to the response sensitivities to these loads of the proposed structure) be envisaged by the designer or by LR as being of a sufficiently high order, then suit-

- able model tests or, if feasible, advanced mathematical hydrodynamic analyses are to be carried out to determine their magnitudes. (See Pt 1, Ch 2, 4.2.2), and
- (b) The structural complexity of the proposed arrangements is limited:

Should, in the judgement of the designer or of LR, the proposed structural arrangements be too complex for normal methods of analysis in use, then direct calculations using advanced structural analysis techniques, for example, finite element analyses, are to be carried out. In such cases the acceptance criteria are to be as for normal methods of analysis unless specially agreed otherwise by LR and the calculations are to comply with the following requirements.

2.1.2 Where direct calculations are carried out the following details are to be submitted:

- (a) a description of the calculation logic and the procedures used, together with the name of any computer program used. Reference should also be made to 3.1.2;
- (b) diagrams of structural modelling;
- (c) a summary of analysis parameters including component sectional properties, boundary conditions, and means of applying the loads;
- (d) a schedule of load cases including a summary of input data for each;
- (e) a sufficiently comprehensive summary of output.

2.1.3 In general, it will not be necessary to submit large volumes of input and output data associated with programs such as finite element analysis unless specifically requested.

2.1.4 The responsibility for specification and input of program data, and the subsequent transcription of output, together with the integrity of the program, rests with the Designer.

■ Section 3 Equivalents

3.1 Alternative arrangements and scantlings

3.1.1 In addition to cases where direct calculations are required by 2.1.1, LR will consider alternative scantlings for pontoon structures which have been derived by direct calculations in lieu of the prescriptive Rule requirements. All direct calculations are to be submitted for examination including the associated load evaluations. The acceptance criteria are to be equivalent to those embodied in the Rules.

3.1.2 LR will consider the use of Designers' programs for direct calculations where it can be established that the program has been properly validated and has previously given satisfactory results when used to perform direct calculations.

General Conditions and Requirements

Part 3, Chapter 1

Sections 4, 5 & 6

■ Section 4 National Regulations

4.1 General

4.1.1 LR, when authorized, will act on behalf of Governments and, if requested, will certify compliance in respect of any appropriate National requirements.

■ Section 5 Inspection and workmanship

5.1 Inspection

5.1.1 Adequate means are to be provided to enable the Surveyor to carry out a satisfactory inspection of all components during each stage of prefabrication, construction and installation.

5.2 Workmanship

5.2.1 All workmanship is to be in accordance with good engineering practice and such that it meets the requirements of the Rules. Unacceptable defects are to be rectified to the satisfaction of the Surveyor before the material is covered with paint, or other coating. The materials and welding are to be in accordance with the requirements of the *Rules for the Manufacture, Testing and Certification of Materials*. The assembly sequence and welding sequence are to be agreed prior to construction and to be to the satisfaction of the LR Surveyor. Plates which have been subjected to excessive heating may be liable to rejection or, exceptionally, may be satisfactorily heat treated before being incorporated into the structure.

■ Section 6 Acceptance testing of pontoons, bridges, ramps and walkways

6.1 Pontoons

6.1.1 **Hose testing.** Any watertight doors, bulkheads, tunnels or weathertight deck closures are to be pressure hose tested, with a hose supply pressure of at least 2,0 bar, from a maximum distance of 1,5 m, to the Surveyor's satisfaction.

6.1.2 **Pressure testing.** Water ballast tanks are to be pressure tested to a 2,40 m head above the highest point of the tank, excluding hatchway, or to the top of the overflow, whichever is the greater.

6.1.3 **Leak testing.** Leak testing is required on fillet weld connections on tank boundaries. This test is also required on erection welds on tank boundaries except for welds made by automatic processes. Selected locations of automatic erection welds and pre-erection manual or automatic welds may be required to be similarly tested at the discretion of the Surveyor taking account of the quality control procedures operating in the yard. This test is carried out by applying a soapy water solution to the weld being tested while the tank is subjected to an air pressure of 0,15 bar. It is recommended that, with a minimum number of personnel in the vicinity of the tank, the air pressure in the tank is raised to 0,20 bar and kept at this level for about one hour to reach a stabilized state, and then lowered to the test pressure prior to inspection. Leak testing is to be carried out before a protective coating is applied.

6.1.4 When a protective coating is to be applied to the internal structure of a tank, the water test may take place after the application of the coating, provided that the structure is carefully examined to ensure that welding and structural stiffening are completed prior to the application of the coating, excluding prefabrication primers. The cause of any discolouration or disturbance of the coating is to be ascertained and any deficiencies repaired.

6.1.5 Pressure testing may be carried out afloat where testing using water cannot be accommodated in dry-dock or on the building site. The testing afloat is to be carried out by separately filling each tank and cofferdam to the test head given in 6.1.2.

6.1.6 Alternative proposals for testing will be considered.

6.2 Bridges, ramps and walkways

6.2.1 Each bridge or walkway span and every ramp span is to be proof tested in its working position by applying appropriate test loads after installation, and following any major repair, renewal or modification to help verify compliance of the structure and its support arrangements with the Rule requirements. Testing is to be carried out throughout high and low tide conditions to allow for the dynamic effects of tidal movement. It should be noted that testing does have some limitations for verifying structural integrity and will not verify fatigue strength.

6.2.2 The magnitude of the proof test load, T , is to be based on the applied design load, W , in tonnes, of the bridge, ramp or walkway section derived from the design UDL x working area, or in the case of ramps and bridges the maximum vehicle load or SWL, as follows:

$$T = 1,25W \text{ for } W \leq 20 \text{ t}$$

$$T = W + 5,0 \text{ t where } 20 \text{ t} < W \leq 50 \text{ t}$$

$$T = 1,1W \text{ where } W > 50 \text{ t}$$

A concentrated load equivalent to a UDL, or vice versa, may be used where appropriate.

General Conditions and Requirements

Part 3, Chapter 1

Sections 6, 7 & 8

6.2.3 Additionally, bridges, ramps and walkways that are raised or lowered when unloaded are to be proof tested to the satisfaction of the Surveyor after installation and after major repair, renewal or alteration as follows:

- (a) The brake or other mechanism, if fitted, is to hold the bridge, ramp or walkway in its most unfavourable position whilst carrying an additional test load equal to 25 per cent of its self weight. The test load is to be evenly distributed over the working surface where this is practicable.
- (b) Any part of the linkspan which may be mechanically hoisted or lowered is also to be operated through at least one complete operating cycle.

6.2.4 Alternative proposals for testing will be considered.

Section 7 Towage certificate

7.1 General

7.1.1 When a towage certificate is requested by the Builder or operators to cover the linkspan while being towed at sea, the scantlings and arrangements will be considered separately.

Section 8 Information required for approval

8.1 General

8.1.1 Before plan approval can commence, the information detailed in this section relating to the site at which the linkspan will operate is to be submitted for consideration.

8.2 Environmental data

8.2.1 All data reflecting the environment in which the linkspan is designed to operate, and which it will experience at its service site are to be submitted. These data include:

- (a) Large scale hydrographic chart of the local area, its seabed topography and its environs.
- (b) Highest and lowest astronomical tides (HAT and LAT) together with details of known exceptional water levels for the site location and the associated return period.
- (c) Maximum operating and survival wind speeds and directions associated with a 50 year return period for the site.
- (d) Maximum and operational significant wave heights and periods and directions associated with a 50 year return period for the site. Information also to include the effects of waves from passing marine craft.
- (e) Maximum current speeds and directions at site including the effects of ships' propulsion units.

- (f) Seabed conditions and likelihood of silting in vicinity of site.
- (g) The anticipated effects of passing marine craft at site.
- (h) For areas subject to sub-zero temperatures the lowest observed daily mean ambient temperature (LODMAT) for the location is to be submitted. See Ch 2,2.1.2.
- (j) Extreme snow and ice loadings.
- (k) Seismic conditions, where appropriate.

8.3 Operational data

8.3.1 Vehicle loading data on ramps, bridges and pontoon decks including:

- (a) Maximum gross vehicle weight with maximum axle loads, associated axle spacings and tyre print data.
- (b) Number of vehicles assumed to be present on the linkspan, loading rate and fatigue load spectrum.
- (c) Number of traffic lanes and direction of traffic.
- (d) Exceptional vehicle loading, including any tracked vehicles or other loadings specified by the Designer.
- (e) Range of height adjustment. Maximum ramp gradients, operational and extreme.
- (f) Vertical geometry profile of ramps at ship to ramp interface and at other points of articulation.

8.3.2 Other applied loading data:

- (a) Design uniformly distributed loadings.
- (b) Loads imposed by ships' ramps including location on berthing face.
- (c) Passenger/pedestrian loadings.
- (d) Any other loadings not specified above.

8.3.3 Berthing data including:

- (a) Size and displacement of ships intending to use the linkspan.
- (b) Berthing contact speeds and approach angles.
- (c) Proposed mode of berthing and means of the ship's position-keeping when berthed.
- (d) Frequency of berthings and Designer's calculations of berthing energy.

8.3.4 Other operational data:

- (a) Coefficients of friction for all sliding support surfaces of bridges, ramps and walkways.
- (b) Maximum inclinations of bridges, ramps and walkways during operation.

8.4 Pontoon structural data

8.4.1 The following plans and information are to be submitted for approval:

- (a) Profile and deck(s).
- (b) Shell plating and stiffening arrangements.
- (c) Sections showing transverse and longitudinal structural members.
- (d) All transverse and longitudinal bulkheads.
- (e) Details of appendages fixed to the pontoon supporting bridges, ramps and walkways.
- (f) Pillars (where fitted).
- (g) Welding and construction details.
- (h) Material grades used in the construction.
- (j) Mooring and towing attachments.

General Conditions and Requirements

Part 3, Chapter 1

Section 8

- (k) Fixed and adjustable ballasting and sounding arrangements. (See also 8.7.1.)
- (l) Locations and weights or loadings from all equipment, fixed or otherwise, which may affect buoyancy calculations.

8.4.2 The following plans and/or information are to be submitted for information purposes where applicable:

- (a) General arrangement.
- (b) Hydrostatic properties.
- (c) Maximum design operating angles of heel and trim.
- (d) Maximum amplitude of dynamic wave-induced pontoon roll and pitch in service.

8.5 Vehicle ramps, bridges, walkways and structural steelwork data

8.5.1 Plans indicating the following information are to be submitted for approval:

- (a) All structural plans, including details of deck plating, deck longitudinals, transverses, girders and any gantries or supporting columns and towers where provided.
- (b) Material specifications.
- (c) All hinges and articulated joints.
- (d) All support arrangements.
- (e) Details of all connections including weld sizes and number, size and grade of bolts where fitted.
- (f) All hoisting arrangements, where applicable, including reeving arrangements, rope sizes and sheave details, and hydraulic cylinders and associated schematics.

8.5.2 The following plans are to be submitted for information where applicable:

- (a) General arrangement, including the positions of any bridge, ramp or walkway at the lowest and highest tides and showing allowances ensuring the linkspan will not foul any obstacle within the operating envelope.

8.6 Mooring and tethering arrangements

8.6.1 Details of the method of securing the linkspan pontoon on-station are to be submitted. See Pt 1, Ch 2, 1.2.1 and 1.3.4.

8.6.2 Details of the mooring system (including size, material grade and design loads of ropes, chain cables, shackles, etc.) and of the tethering components (e.g. guidepiles, yokes, brackets, etc.) are to be submitted for approval.

8.7 Other information

8.7.1 Pontoon ballasting arrangements and maximum and minimum ballast drafts are to be indicated for the operating condition and, where applicable, towage conditions. Where ballasting is adjusted using compressed air, the maximum air pressure is to be specified. The envisaged maximum static angles of heel and trim, are also to be specified.

8.7.2 All test procedures are to be submitted in accordance with Section 6.

8.7.3 Where an impressed current cathodic protection system is fitted, plans showing the proposed layout of anodes, reference cells and wiring diagrams are to be submitted.

8.7.4 The results of any model tests are to be submitted.

8.7.5 The design life of the linkspan is to be advised. A fatigue assessment in accordance with a recognized National or International Standard is to be made and submitted for consideration. See Ch 3, 4.1.2.

8.7.6 Information required for engineering systems is listed in Pt 4, Ch 1, 2.

Materials

Part 3, Chapter 2

Section 1

Section

1 Materials of construction

2 Fracture control

3 Corrosion protection

Section 1 Materials of construction

1.1 General

1.1.1 In general the Rules relate to the construction of linkspans in steel or aluminium alloys, although consideration will be given to the use of other materials.

1.1.2 The materials used in the construction of classed linkspans are to be manufactured and tested in accordance with the requirements of the *Rules for the Manufacture, Testing and Certification of Materials* (hereinafter referred to as the Rules for Materials). Materials for which provision is not made therein may be accepted, provided that they comply with an approved specification and such tests as may be considered necessary.

1.2 Steel

1.2.1 Steel having a specified minimum yield stress of 235 N/mm² (24 kgf/mm²) is regarded as mild steel.

1.2.2 For the determination of pontoon scantlings where higher tensile steel is used, a higher tensile steel factor, k , given in Table 2.1.1, is to be applied as indicated in the various prescriptive scantling formulae given in Chapter 4.

Table 2.1.1 Higher tensile steel factor, k

Specified minimum yield stress in N/mm ²	k
235	1,0
265	0,92
315	0,78
340	0,74
355	0,72
390	0,68
NOTE Intermediate values by linear interpolation.	

1.3 Aluminium

1.3.1 Except where otherwise stated, equivalent scantlings are to be derived as follows where aluminium alloys are used:

Plating thickness;

$$t_a = t_s c \sqrt{k_a}$$

Section modulus of stiffeners;

$$Z_a = Z_s k_a c$$

where

c = 0,95 for high corrosion resistant alloy
= 1,00 for other alloys

$$k_a = \frac{245}{\sigma_a}$$

t_a = equivalent thickness of aluminium plating

t_s = thickness of mild steel plating

Z_a = equivalent section modulus of aluminium stiffener

Z_s = section modulus of mild steel stiffener

σ_a = 0,2 per cent proof stress or 70 per cent of the ultimate strength of the material, whichever is the lesser (N/mm²).

1.3.2 In general, for welded structures, the maximum value of σ_a to be used in the derivation of scantlings is that of aluminium in the welded condition. However, consideration will be given to using unwelded values depending upon the weld line location, or other heat affected zones, in relation to the maximum applied stress on the member.

1.3.3 A comparison of the mechanical properties for selected welded and unwelded alloys is given in Table 2.1.2.

1.3.4 Where strain hardened grades (designated Hxxx) are used, adequate protection by coating is to be provided to avoid the risk of stress corrosion cracking.

Materials

Part 3, Chapter 2

Sections 1 & 2

Table 2.1.2 Minimum mechanical properties for selected aluminium alloys

Alloy	Condition	0,2% proof stress N/mm ²		Ultimate tensile strength N/mm ²	
		Unwelded	Welded (see Note 4)	Unwelded	Welded (see Note 4)
5754	O/H111	80	80	190	190
5083	O/H111	125	125	275	275
5083	H112	125	125	275	275
5083	H116/H321	215	125	305	275
5086	O/H111	100	95	240	240
5086	H112	125 (see Note 2)	95	250 (see Note 2)	240
5086	H116/H321	195	95	275	240
6005A (see Note 1)	T5/T6	215	100	260	160
	Extruded: Open Profile Extruded: Closed Profile	215	100	250	160
6061 (see Note 1)	T5/T6	240	125	290	160
	Rolled	240	125	260	160
	Extruded: Open Profile Extruded: Closed Profile	205	125	245	160
6082	T5/T6	240	125	280	190
	Rolled	260	125	310	190
	Extruded: Open Profile Extruded: Closed Profile	240	125	290	190

NOTES

- These alloys are not normally acceptable for application in direct contact with sea-water.
- See also Table 8.1.4 in Chapter 8 of the Rules for Materials.
- The mechanical properties to be used to determine scantlings in other types and grades of aluminium alloy manufactured to national or proprietary standards and specifications are to be individually agreed with LR, see also Ch 8,1.1.5 of the Rules for Materials.
- Where detail structural analysis is carried out 'Unwelded' stress values may be used away from heat affected zones and weld lines, see also 1.3.2.

Section 2

Fracture control

2.1 Grades of steel

2.1.1 The resistance to fracture is controlled, in part, by the notch toughness of the steel used in the structure. Steels with different levels of notch toughness are specified in the Rules for Materials. The grade of steel to be used is, in general, related to the thickness of the material and the stress pattern associated with its location.

2.1.2 In general for locations where the Lowest Observed Daily Mean Ambient Temperature (LODMAT) is not less than 0°C the grade of steel used in the construction of the primary strength members of the facility is to comply with Table 2.2.1.

2.1.3 Tee or cruciform welded connections should be avoided wherever possible. Where unavoidable, and the plate material is subject to significant strains in a direction perpendicular to the rolled surfaces, it is recommended that consideration be given to the use of special plate material with specified through thickness properties, as detailed in Ch 3,8 of the Rules for Materials.

Table 2.2.1 Steel grades

Thickness t (mm)	Mild steel	H.T. steel
$t \leq 20$	A	AH
$20 < t \leq 25$	B	AH
$25 < t \leq 40$	D	DH
$t > 40$	E	EH

2.1.4 For facilities with sub-zero design temperatures, the material for primary structural members is to comply with the requirements of Table 2.2.2.

Table 2.2.2 Grades of steel for minimum design temperatures below 0°C

Minimum design temperature, in °C	Thickness, in mm	Grades of steel
0 to -10	$t \leq 12,5$ $12,5 < t \leq 25,5$ $t > 25,5$	B/AH D/DH E/EH
-10 to -25	$t \leq 12,5$ $t > 12,5$	D/DH E/EH

Section 3 Corrosion protection

3.1 General

3.1.1 Where bimetallic connections are made, measures are to be incorporated to preclude galvanic corrosion.

3.2 Fabrication primers

3.2.1 Where a primer is used to coat steel after surface preparation and prior to fabrication, the composition of the coating is to be such that it will have no significant deleterious effect on subsequent welding work and that it is compatible with the paints or other coatings subsequently applied.

3.2.2 When unapproved primers are used tests are to be made as detailed in 3.2.3 to 3.2.5 to determine the influence of the primer coating on the characteristics of welds.

3.2.3 Three butt weld assemblies are to be tested using plate material 20 to 25 mm thick. A 'V' preparation is to be used and, prior to welding, the surfaces and edges are to be treated as follows:

- (a) Assembly 1 – Uncoated.
- (b) Assembly 2 – Coated in accordance with manufacturer's instructions.
- (c) Assembly 3 – Coated to a thickness approximately twice the manufacturer's instructions.

3.2.4 Tests as follows are to be taken from each test assembly:

- (a) **Radiographs.** These are to have a sensitivity of better than two per cent of the plate thickness under examination, as shown by an image quality indicator.
- (b) **Photo-macrographs.** These may be of actual size and are taken from near each end and from the centre of the weld.
- (c) **Face and reverse bend test.** The test specimens are to be bent by pressure or hammer blows round a former diameter equal to three times the plate thickness.
- (d) **Impact tests.** These are to be carried out at ambient temperature on three Charpy V-notch test specimens prepared in accordance with Ch 2,3 of the Rules for Materials. The specimens are to be notched at the centreline of the weld perpendicular to the plate surface.

3.2.5 The tests are to be carried out in the presence of an LR Surveyor or with the agreement of the Surveyor by an independent laboratory specializing in such work. A copy of the test report is to be submitted together with radiographs and macrographs.

3.3 Internal cathodic protection

3.3.1 Particular attention is to be given to the location of anodes, where fitted, in relation to the structural arrangements and openings of the tank.

3.3.2 Anodes are to be of approved design and sufficiently rigid to avoid resonance in the anode support. Steel cores are to be fitted, and these are to be designed to retain the anode even when the latter is wasted.

3.3.3 Anodes are to be attached to the structure in such a way that they remain secure both initially and during service. The following methods of attachment would be acceptable:

- (a) Steel core connected to the structure by continuous welding of adequate section.
- (b) Steel core bolted to separate supports, provided that a minimum of two bolts with lock nuts are used at each support. The separate supports are to be connected to the structure by continuous welding of adequate section.
- (c) Approved means of mechanical clamping.

3.3.4 Anodes are to be attached to stiffeners, or may be aligned in way of stiffeners on plane bulkhead plating, but they are not to be attached to the shell. The two ends are not to be attached to separate members which are capable of relative movement.

3.3.5 Where cores or supports are welded to the main structure, they are to be kept clear of the toes of brackets and similar stress raisers. Where they are welded to asymmetrical stiffeners, they are to be connected to the web with the welding kept at least 25 mm away from the edge of the web. In the case of stiffeners or girders with symmetrical face plates, the connection may be made to the web or to the centreline of the face plate but well clear of the free edges. However, it is recommended that anodes are not fitted to face plates of higher tensile steel longitudinals.

3.4 Aluminium and magnesium anodes

3.4.1 Aluminium anodes are not to be located under tank hatches unless protected by adjacent structure.

3.4.2 Magnesium or magnesium alloy anodes are permitted only in tanks intended solely for water ballast.

3.5 External pontoon or steelwork protection

3.5.1 Suitable protection of the underwater portion of the pontoon and all submerged steelwork is to be provided.

3.5.2 Where an impressed current cathodic protection system is fitted, plans showing the proposed layout of anodes, reference cells and wiring diagrams are to be submitted.

3.5.3 The arrangement for glands, where cables pass through the shell, are to include a small cofferdam.

3.5.4 Where an ***IWS** (In-water Survey) notation is to be assigned (see Pt 1, Ch 2,3.4.1), protection of the underwater portion of the pontoon and/or other underwater steelwork is to be provided by means of a suitable high resistant paint applied in accordance with the manufacturer's requirements. Details of the high resistant paint are to be submitted for information.

3.6 Corrosion protection coatings for ballast spaces

3.6.1 At the time of new construction, all ballast spaces are to have an efficient protective coating, epoxy or equivalent, applied in accordance with the paint manufacturer's recommendations. The durability of the coatings could affect the frequency of survey of the spaces and light coloured coatings would assist in improving the effectiveness of subsequent surveys. It is therefore recommended that these aspects be taken into account by those agreeing the specification for the coatings and their application.

3.6.2 For further information and recommendations regarding the coating of ballast spaces see the *List of Paints, Resins, Reinforcements and Associated Materials* published by LR.

General Structural Design Requirements

Part 3, Chapter 3

Sections 1 & 2

Section

1 General

2 Structural idealization for pontoons

3 Design loading

4 Fatigue assessment

5 Model tests

■ Section 1 General

1.1 Introduction

1.1.1 This Chapter indicates the general outline of the structural requirements which apply to the various elements which may be included in a linkspan namely, pontoons, bridges, ramps, walkways and supporting steelwork.

1.2 Pontoons

1.2.1 The structural requirements for the basic hulls of pontoons are highly prescriptive and are generally the same as those for pontoons covered by Parts 3 and 4 of the *Rules and Regulations for the Classification of Ships* (hereinafter referred to as the Rules for Ships).

1.2.2 Pontoon designs complying with these basic hull requirements may be deemed to safely accommodate *inter alia*:

- hydrostatic loads on the hull resulting from heeling and trimming operations whilst the pontoon is freely floating up to the point of deck edge immersion; and
- any direct hydrodynamic loads on the hull which might occur at the geographic location for which class has been assigned,
- any additional loading from the effects of propeller or thruster wash from the berthing ship.

1.2.3 For greater pontoon immersions than deck edge immersion, see Ch 4, 1.1.4.

1.2.4 Any further loads on the basic pontoon structure which arise as a result of vehicular traffic and/or of support given by the pontoon to associated bridges, vehicle ramps, and walkways or other applied loadings due to vehicle or pedestrian transfer are to be transmitted to the hull by suitable structural appendages fixed to the basic pontoon structure. These appendages are to comply with the load and design criteria given in Chapters 5 or 6, as appropriate.

1.2.5 Structural reinforcement of the basic hull in way of these appendages is to be provided and suitably connected into the pontoon structure. The composite structure is also to comply with the load and design criteria given in Ch 5, Sections 3 and 4 as appropriate.

1.2.6 For pontoons with length to depth ratios exceeding six, additional longitudinal strength calculations should be carried out.

1.3 Bridges and vehicle ramps

1.3.1 The structural requirements for bridges and vehicle ramps are less prescriptive than those for basic pontoon structures. They are determined from an allowable stress approach, using factored loads and other requirements given in Chapter 5.

1.3.2 Specific details of the structural requirements for bridges and vehicle ramps are given in Chapter 5.

1.4 Walkways

1.4.1 The structural requirements for walkways are less prescriptive than those for basic pontoon structures. They are determined from an allowable stress approach, using factored loads, and other requirements given in Chapter 6.

1.4.2 Specific details for the structural requirements for walkways are given in Chapter 6.

■ Section 2 Structural idealization for pontoons

2.1 Geometric properties of section

2.1.1 The symbols used in this sub-Section are defined as follows:

b = the actual width, in metres, of the load-bearing plating, i.e. one-half of the sum of spacings between parallel adjacent members or equivalent supports

f = $0,3 \left(\frac{l}{b} \right)^{2/3}$, but is not to exceed 1,0. Values of

this factor are given in Table 3.2.1

l = the overall length of the primary support member, in metres, see Fig. 3.2.3

t_p = the thickness of the attached plating in mm. Where this varies, the mean thickness over the appropriate span is to be used.

2.1.2 The effective geometric properties of rolled or built sections may be calculated directly from the dimensions of the section and associated effective area of attached plating. Where the web of the section is not normal to the attached plating, and the angle exceeds 20°, the properties of the section are to be determined about an axis parallel to the attached plating.

General Structural Design Requirements

Part 3, Chapter 3

Section 2

Table 3.2.1 Section geometry factor, f

$\frac{l}{b}$	f	$\frac{l}{b}$	f
0,5	0,19	3,5	0,69
1,0	0,30	4,0	0,76
1,5	0,39	4,5	0,82
2,0	0,48	5,0	0,88
2,5	0,55	5,5	0,94
3,0	0,62	6 and above	1,00

NOTE
Intermediate values to be obtained by linear interpolation.

2.1.3 The geometric properties of rolled or built stiffener sections and of swedges are to be calculated in association with the effective area of attached load bearing plating of thickness t_p and of width 600 mm or $40t_p$ whichever is the greater. In no case, however, is the width of plating to be taken as greater than either the spacing of the stiffeners or the width of the flat plating between swedges, whichever is appropriate. The thickness, t_p , is the actual thickness of the attached plating. Where this varies, the mean thickness over the appropriate span is to be used.

2.1.4 The effective section modulus of a corrugation over a spacing p is to be calculated from the dimensions and, for symmetrical corrugations may be taken as:

$$Z = \frac{d_w}{6000} (3b t_p + c t_w) \text{ cm}^3$$

where d_w , b , t_p , c and t_w are measured in mm, and are as shown in Fig. 3.2.1. The value of b is to be taken not greater than:

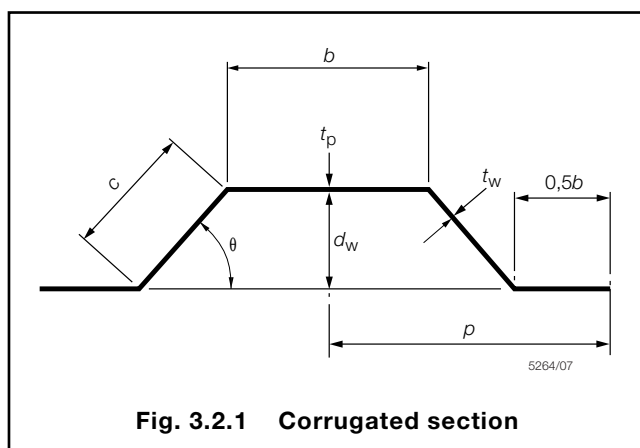
$50t_p \sqrt{k}$ for welded corrugations

$60t_p \sqrt{k}$ for cold formed corrugations

The value of θ is to be not less than 40° .

The moment of inertia is to be calculated from:

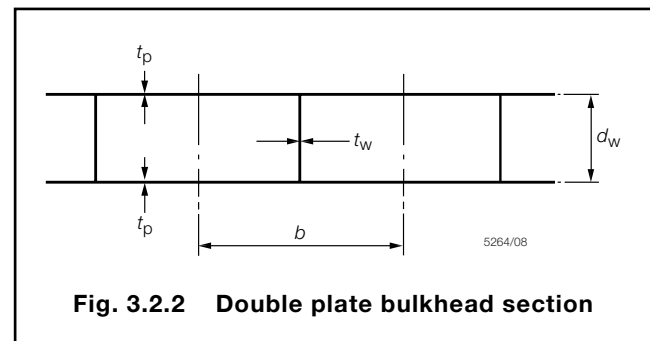
$$I = \frac{Z}{10} \left(\frac{d_w}{2} \right) \text{ cm}^4$$



2.1.5 The section modulus of a double plate bulkhead over a spacing b may be calculated as:

$$Z = \frac{d_w}{6000} (6f b t_p + d_w t_w) \text{ cm}^3$$

where d_w , b , t_p and t_w are measured, in mm, and are as shown in Fig. 3.2.2.



2.1.6 The effective section modulus of a built section may be taken as:

$$Z = \frac{a d_w}{10} + \frac{t_w d_w}{6000} \left(1 + \frac{200 (A - a)}{200A + t_w d_w} \right) \text{ cm}^3$$

where

a = the area of the face plate of the member, in cm^2

d_w = the depth, in mm, of the web between the inside of the face plate and the attached plating. Where the member is at right angles to a line of corrugations, the minimum depth is to be taken

t_w = the thickness of the web of the section, in mm

A = the area of the attached plating in cm^2 , see 2.1.7. If the calculated value of A is less than the face area a , then A is to be taken as equal to a .

2.1.7 The geometric properties of primary support members (i.e. girders, transverses, webs, stringers, etc.) are to be calculated in association with an effective area of attached load bearing plating, A , determined as follows:

(a) For a member attached to plane plating:

$$A = 10f b t_p \text{ cm}^2$$

where b is as defined in 2.1.1.

(b) For a member attached to corrugated plating and parallel to the corrugations (where b is as defined in 2.1.4, see also Fig. 3.2.1):

$$A = 0,01b t_p \text{ cm}^2$$

(c) For a member attached to corrugated plating and at right angles to the corrugations:

A is to be taken as equivalent to the area of the face plate of the member.

2.2 Determination of span point

2.2.1 The effective length, l_e , of a stiffening member is generally less than the overall length, l , by an amount which depends on the design of the end connections. The span points, between which the value of l_e is measured, are to be determined as follows:

- (a) For rolled or built secondary stiffening members:
The span point is to be taken at the point where the depth of the end bracket, measured from the face of the secondary stiffening member is equal to the depth of the member. Where there is no end bracket the span point is to be measured between primary member webs. For double skin construction the span may be reduced by the depth of the primary member web stiffener, see Fig. 3.2.3.

- (b) For primary support members:
The span point is to be taken at a point distant b_e from the end of the member (see Fig. 3.2.3) where:

$$b_e = b_b \left(1 - \frac{d_w}{d_b} \right)$$

2.2.2 Where the stiffener member is inclined to a vertical or horizontal axis and the inclination exceeds 10° , the span is to be measured along the member.

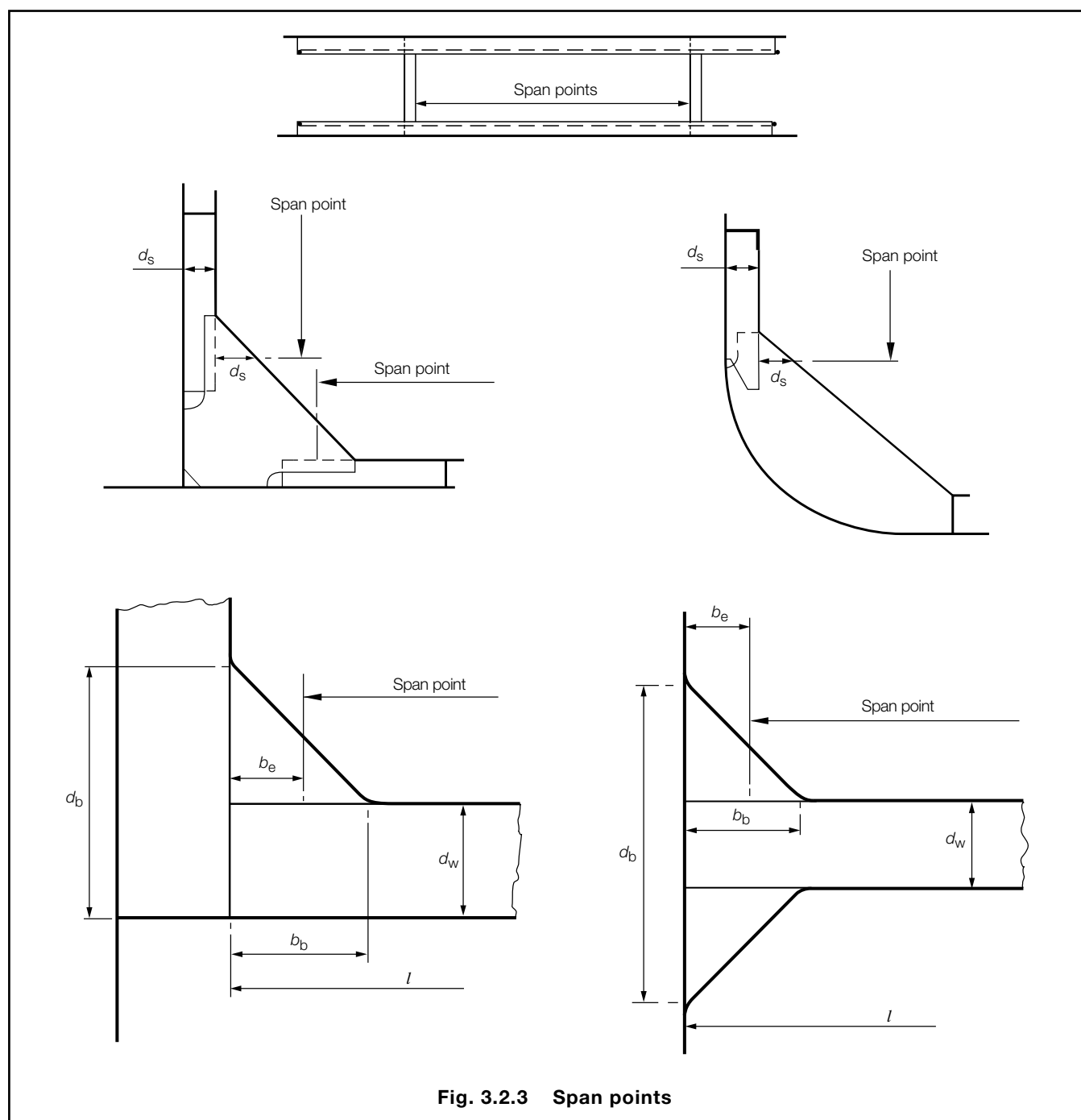


Fig. 3.2.3 Span points

General Structural Design Requirements

Part 3, Chapter 3

Sections 2 & 3

2.2.3 It is assumed that the ends of stiffening members are substantially fixed against rotation and displacement. If the arrangement of supporting structure is such that this condition is not achieved, consideration will be given to the effective span to be used for the stiffener.

Section 3 Design loading

3.1 General

3.1.1 This Section describes the various types of loadings to be applied to linkspans when assessing their structural adequacy at the intended service location.

3.2 Hydrostatic loads

3.2.1 The scantlings of pontoons, buoyancy tanks and buoyancy spaces in linkspan bridge sections are to be assessed on the basis of a static pressure load equivalent to the geometric depth, D of the pontoon or buoyancy tank.

3.2.2 Submerged buoyancy tank scantlings are to be based on the maximum depth of water above the base of the tank.

3.3 Dead loads

3.3.1 The self weight, including weight of steel, welding, any surfacing or cladding material, or machinery items is to be taken into account in the calculations of bridges, ramps, walkways, support structures, bearings, connections or joints, as appropriate.

3.4 Vehicle loads

3.4.1 Individual tyre prints (load and patch area) are to be considered when establishing the deck plate thickness of pontoons, ramps and bridges.

3.4.2 Axle loads and spacings are to be considered for the adequacy of deck strength members.

3.4.3 To allow for the possibility of emergency braking or skidding incidents, a horizontal load of $0,2 \times$ vehicle weight is to be considered in conjunction with the vertical vehicle loadings.

3.4.4 A design uniformly distributed load (UDL) may be considered for establishing the overall, global strength of vehicle carrying decks, ramps or bridges. Such a UDL is to be used for defining the rated load, or SWL, where appropriate, of any deck, ramp or bridge structure and for determining the appropriate proof test load.

3.4.5 Alternatively, vehicle carrying decks, ramps or bridges may be assessed on the basis of HA and HB loading, or other equivalent National or International loading Standards. Definitions of HA and HB loading are given in Chapter 9.

3.4.6 When requested the loadings from trains and railway wagons will be specially considered.

3.5 Walkway loading

3.5.1 Walkways are generally assessed on the basis of a pedestrian UDL of 5 kN/m^2 acting over the internal floor area, unless otherwise stated by the designer.

3.6 Wind loading

3.6.1 Each linkspan, and its mooring or tethering arrangements, is to be capable of withstanding:

- the specified maximum wind speed in which the linkspan will continue in normal service; and
- an extreme, out of normal service, wind speed – based on a 1 in 50 years return period.

3.6.2 The design wind speeds are to be based on local climatological data.

Where the wind speeds are not defined by reliable local meteorological records, the following values may be used:

- 20 m/s for the normal in-service condition
- 63 m/s for the out-of-service condition.

3.6.3 The wind force, F_w acting on the linkspan structure is to be calculated from the expression:

$$F_w = A P C_f$$

where

A = the effective area of the structure, i.e. the solid area projected on a plane perpendicular to the wind direction, in m^2

P = wind pressure in N/m^2

where

$$P = 0,613v^2$$

and

v = wind speed, in m/s

C_f = force coefficient in the direction of the wind.

3.6.4 The value of C_f will depend on other factors including:

- aerodynamic slenderness
- section ratios
- shielding factors
- solidity factor

Definitions of these various factors are given in Chapter 9.

3.7 Current loading

3.7.1 Each linkspan is to be capable of withstanding the maximum prevailing current speed without loss of effective station-keeping capability.

General Structural Design Requirements

Part 3, Chapter 3

Section 3

3.7.2 The maximum current speed is to be based on the most unfavourable combinations of tide, surge and wind induced currents for a return period of 1 in 50 years, or other equivalent available data.

3.7.3 The current force, F_c acting on the linkspan is to be calculated from the expression.

$$F_c = 0,5 C_D \rho v^2 A \quad \text{kN}$$

where

C_D = drag coefficient in direction of current

ρ = density of water, in t/m^3

v = incident current velocity impinging on the pontoon, in m/s

A = submerged area of pontoon normal to the current flow direction, in m^2 .

3.7.4 The calculation of the drag coefficient, C_D , can be complex and will depend on the shape of the pontoon, extent of marine growth, depth of water under the pontoon and breadth/depth ratio of pontoon. A value of C_D may be calculated in accordance with the method in Chapter 9.

3.8 Wave loading

3.8.1 In general, linkspans are to be located in sheltered positions where the effects of wave impingement will not be severe. The forces due to any wave action are to be considered in the design of the mooring or tethering system.

3.8.2 Where it can be assumed that waves impinging on pontoons will be reflected, forces should be calculated as for a standing wave with the pontoon assumed to be located at a node point.

3.8.3 The maximum pressure, P_y on the pontoon elevation, y , relative to the still water level may be taken as:

$$P_y = \rho g y + \rho g H_{inc} \cosh [2\pi(y + d)/L] / \cosh (2\pi d/L) \quad \text{kN/m}^2$$

where

ρ = mass density of water, in t/m^3

g = acceleration due to gravity, in m/s^2

y = elevation on pontoon relative to still water level measured positively upwards, in metres

H_{inc} = incident wave height, in metres

d = still water depth, in metres

L = wavelength (crest-to-crest), in metres.

3.8.4 For locations where wave drift occurs the mean wave drift force, F_{wd} for an irregular sea may be calculated using the following equation:

$$F_{wd} = \frac{\rho g L H_s^2}{16} \quad \text{kN}$$

where

H_s = significant wave height, in metres.

3.8.5 For linkspans being specially considered under Pt 1, Ch 2,1.2.3 a more rigorous treatment of the effects of wave action is required. Reference should be made to BS 6349: Parts 1 and 6, or any other relevant National Standard.

3.9 Ship induced loadings

3.9.1 Where appropriate, linkspans are to be designed to accommodate any horizontal and vertical forces from the end berthing manoeuvres of ships for:

- (a) normal, operational berthing contact;
- (b) abnormal, or heavy berthing contact.

3.9.2 The berthing energy, E of the ship is to be calculated from the equation:

$$E = 0,5m (V \cos \alpha)^2 \quad \text{kNm}$$

where

m = ship's maximum displacement, in tonnes

V = ship's contact speed, in m/s

α = approach angle of ship.

3.9.3 The reaction force, R imparted into the linkspan's structure by the fender's absorption of the berthing energy is to be obtained from the manufacturer's published performance curves for the particular fender installed. It is recommended that R is increased by 10 per cent, or otherwise as suggested by the manufacturer, to allow for possible variations in the nominal values obtained from the performance curves.

3.9.4 To allow for heavy berthing incidents caused by possible accidental occurrences, the ultimate energy absorption capacity of fenders is to be twice that for normal conditions. Any heavy berthing incident resulting in damage, defect or breakdown which could adversely affect the ability of the linkspan to accommodate the conditions for which a Class has been assigned is to be reported to LR without delay, see Pt 1, Ch 2,1.1.7.

3.9.5 Where appropriate (see Pt 1, Ch 2,1.2.2), linkspans are also to be considered for the effects of the following other ship induced loadings:

- (a) Mooring forces transmitted to the linkspan, see Pt 1, Ch 2,1.2.2.
- (b) For linkspans that derive support from the berthed ship, any forces applied through the connecting strops or links caused by motion of the ship.
- (c) The forces of water jets or other propulsion units that may impinge on submerged parts of the linkspan.
- (d) The effects of wash from passing marine craft.
- (e) The effects of vehicles braking or trains striking the buffers when on board the berthed ship.

3.10 Towage loading

3.10.1 Where it is intended to tow the linkspan from its construction site to port of operation, it will be necessary to assess the pontoon structure for the appropriate loadings associated with the tow voyage, in addition to the hydrostatic load and other loads defined previously.

3.11 Snow and ice loading

3.11.1 Where appropriate, and unless otherwise stated by the designer, snow and ice loading of 2 kN/m^2 is to be applied to surfaces within 12 per cent of the horizontal.

■ Section 4 Fatigue assessment

4.1 General

4.1.1 The design life of the linkspan is to be specified.

4.1.2 For all critical components subject to significant cyclical loading a fatigue assessment in accordance with a recognized National or International Standard is to be made and submitted for consideration. This will apply especially to all articulated connections, support points and traffic lane structures, particularly to those spanning between a pontoon and the shore where the effects of continuous pontoon movement and sliding friction bearings may be significant.

4.1.3 Consideration should also be given to details subject to small amplitude motions of the pontoon or other buoyant support causing a high number of cycles at low stress levels.

■ Section 5 Model tests

5.1 General

5.1.1 Linkspans, which in the opinion of LR, are likely to be exposed to incalculable environmental conditions including combinations of swell/wave should, in the absence of other evidence, have model tests carried out to establish the likely behavioural response of the linkspan to these effects.

5.1.2 Model tests are to be carried out where the effects of passing ships or the effects of the berthing ship's propulsion units are, in the opinion of the Designer, likely to be significant.

5.1.3 Testing is to be carried out by a recognized specialist acceptable to LR and the tests are to represent accurately the conditions prevailing at the location of the linkspan.

5.1.4 Model tests may be either physical or mathematical as agreed with LR.

5.1.5 Results of any model tests are to be submitted.

Pontoons

Part 3, Chapter 4

Sections 1 & 2

Section

- 1 **General**
- 2 **Longitudinal strength**
- 3 **Hull envelope plating**
- 4 **Hull envelope framing**
- 5 **Bulkheads**
- 6 **Pillars**

■ Section 1 General

1.1 Application

1.1.1 This Chapter applies to pontoons used for providing buoyant support for ship-to-shore ramps forming part of a linkspan.

1.1.2 Where required, pontoons are to be fitted with adequate arrangements for towing. In general, such arrangements are to consist of, or be equivalent to, not less than two sets of bollards, each set being suitable for accepting a towline of suitable breaking strength.

1.1.3 For pontoons with an $L > 6D$ (see 1.3.1), longitudinal strength calculations are to be carried out in accordance with, Pt 3, Ch 4 of the *Rules and Regulations for the Classification of Ships* (hereinafter referred to as the Rules for Ships).

1.1.4 Pontoons that are submerged to act as buoyancy chambers will be specially considered taking into account the increase in hydrostatic pressure. Stability must also be considered for this type of buoyant arrangement.

1.1.5 Pontoons which are designed to take the ground will be specially considered.

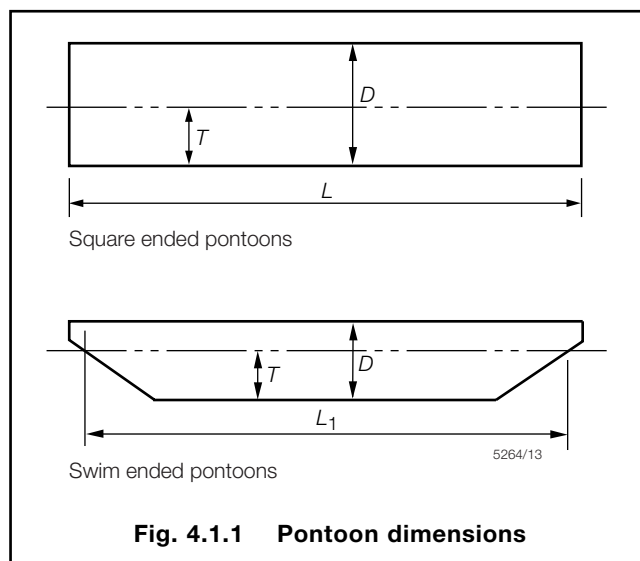
1.2 Information required for approval

1.2.1 Reference is to be made to Ch 1,8 regarding information to be submitted for approval.

1.3 Symbols and definitions

1.3.1 The Rule length, L , is to be taken as the overall length for square ended pontoons, or for pontoons with swim ends L need not exceed 97 per cent of the extreme length at the waterline at maximum working draught condition, L_1 , see Fig. 4.1.1.

1.3.2 Breadth, B , is the greatest moulded breadth, in metres.



1.3.3 Depth, D , is measured, in metres, at the middle of the length, L , from top of bottom plating to top of the deck plating at side on the uppermost continuous deck.

1.3.4 Draught, T , is the maximum working draught, in metres, measured from top of bottom plating.

1.3.5 Head, h , in metres, is to be taken as:

- for bottom longitudinals, frames, girders and trans-verses: the depth D
- for side longitudinals: the distance of the longitudinal below the deck at side, but not less than $0,01L + 0,7$
- for side frames and transverses: the distance from the mid-point of span to the deck at side, but not less than $0,01L + 0,7$
- for weather deck longitudinals and transverses: a head of $0,01L + 0,7$.

1.4 Longitudinal or transverse framing

1.4.1 Pontoons used for this application may be longitudinally or transversely framed.

■ Section 2 Longitudinal strength

2.1 Design loads

2.1.1 The longitudinal strength of pontoons with $L/D > 6$ is to be considered for the worst combination of imposed loadings, see Ch 3,3.

2.2 Calculation of pontoon section modulus

2.2.1 Section modulus calculations are required on all pontoons with an $L/D > 6$.

Pontoons

Part 3, Chapter 4

Sections 2 & 3

2.2.2 All continuous longitudinal structural components are to be included in the calculation of the inertia of the pontoon midship section, where appropriate, and the lever z is to be measured vertically from the neutral axis to the top of bottom plating and to the moulded strength deck line at the side. Where the deck is stepped the hull section modulus for sections between the deck overlaps may be calculated using a mean height h_{mean} , as indicated in Fig. 4.2.1. If the deck thickness varies between the stepped decks, the lesser value is to be used in the calculation of section modulus.

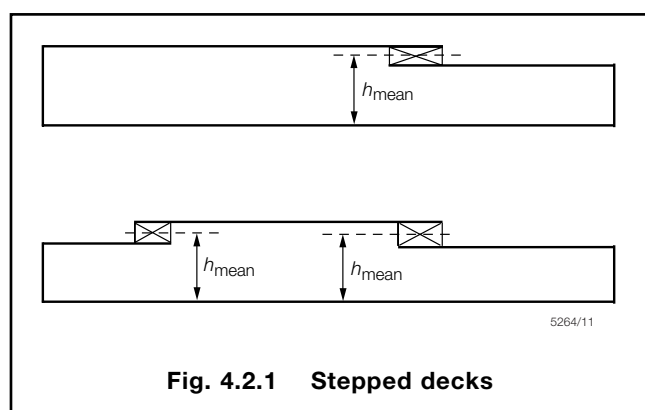


Fig. 4.2.1 Stepped decks

2.2.3 Deck openings having a length in the fore and aft directions exceeding 2,5 m or a breadth exceeding 1,2 m or $0,04B$ m, whichever is the lesser, are always to be deducted from the sectional areas used in the section modulus calculation.

2.2.4 Deck openings smaller than those referred to in 2.2.3 including manholes, need not be deducted provided they are isolated and the sum of their breadths or shadow area breadths, see 2.2.5, in one transverse section does not exceed $0,06(B_1 - \Sigma b_1)$

where

B_1 = breadth of pontoon at section considered

Σb_1 = sum of breadths of deductible openings

Where a large number of deck openings are proposed in any transverse space, special consideration will be required.

2.2.5 In the calculation of deduction-free openings, the openings are assumed to have longitudinal extensions as shown by the shaded areas in Fig. 4.2.2. The shadow area is obtained by drawing two tangent lines to an opening angle of 30° . The section to be considered should be perpendicular to the centreline of the pontoon and should result in the maximum deduction in each transverse space.

2.2.6 Isolated openings in longitudinals or longitudinal girders need not be deducted if their depth does not exceed 25 per cent of the web depth with a maximum depth for scallops of 75 mm.

2.2.7 Openings are considered isolated if they are spaced more than 1 m apart in either the transverse or longitudinal direction.

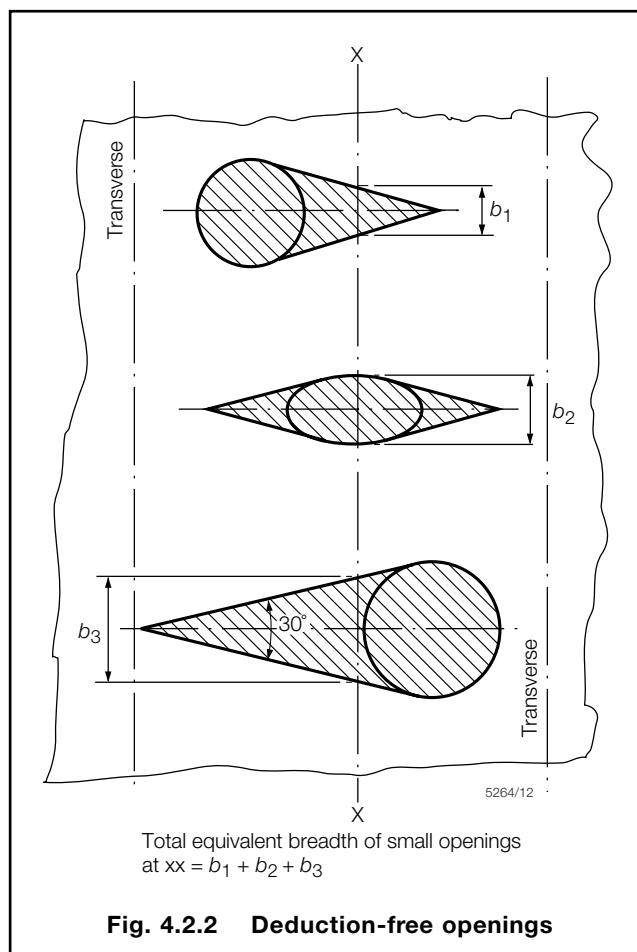


Fig. 4.2.2 Deduction-free openings

2.2.8 Deck openings should be avoided in areas of high stress.

2.3 Permissible hull vertical bending and shear stresses

2.3.1 The permissible stress for hull vertical bending, σ , is given by:

$$\sigma = \frac{175}{k} \text{ N/mm}^2$$

2.3.2 The permissible shear stress, τ , is given by:

$$\tau = \frac{110}{k} \text{ N/mm}^2$$

where

k = material factor, see Ch 2,1.2.

Section 3 Hull envelope plating

3.1 Bottom shell plating

3.1.1 The bottom shell plating thickness is to comply with the requirements of Table 4.3.1.

Pontoons

Part 3, Chapter 4

Section 3

Table 4.3.1 Bottom shell and bilge plating

Location	Longitudinal framing	Transverse framing
(1) Bottom plating	The greater of the following: (a) $t = \frac{0,001s_1 (0,043L + 10)}{\sqrt{k}}$ (b) $t = 0,00582s_1 \sqrt{h_{T2} k}$	The greater of the following: (a) $t = \frac{0,001s f_1 (0,056L + 16,7)}{\sqrt{k}}$ (b) $t = 0,00705s_1 \sqrt{h_{T2} k}$
Symbols		
<p>L, D, T as defined in 1.3 s = spacing of frames, beams or longitudinals, in mm S = spacing or mean spacing of girders, transverses or floors, in metres k = material factor, see Ch 2,1.2 C_w = wave head, in metres $= 7,71 \times 10^{-2} L e^{-0,0044L}$ where e is the base of natural logarithms 2,71828</p>		
<p>$f_1 = \frac{1}{1 + \left(\frac{s}{1000S}\right)^2}$ $h_{T2} = (T + 0,5C_w)$, in metres but need not be taken greater than 1,27 m $s_1 = s$, but is not to be taken less than the smaller of $470 + \frac{L}{0,6}$ mm or 700 mm</p>		

3.2 Side and end shell plating

3.2.1 The side and end shell plating thickness is to comply with the requirements of Table 4.3.2.

3.2.2 Sea inlets, or other openings, are to have well rounded corners and so far as possible, are to be kept clear of the bilge radius, if any. Openings on, or near to, the bilge radius are to be elliptical. The thickness of sea inlet box plating is to be the same as the adjacent shell, but not less than 12,5 mm and need not exceed 25 mm.

3.3 Deck plating

3.3.1 The pontoon deck plating thickness, t , is to comply with the requirements for strength/weather deck plating given in Table 4.3.3.

3.3.2 Additionally, where the pontoon deck will be subject to vehicular loading, the plating is to be designed for the maximum tyre print and axle loads that will use the linkspan.

3.3.3 Details of the vehicle types using the deck are to be submitted. These are to include:

- Wheel loads.
- Axle and wheel spacings.
- Tyre print dimensions.
- Type of tyre fitted (solid or pneumatic).

3.3.4 The deck plating thickness, t , is to be not less than:

$$t = t_1 + t_c \text{ mm}$$

where

$$t_c = \text{wear and wastage allowance} = 1,5 \text{ mm}$$

$$t_1 = \frac{\alpha s}{1000\sqrt{k}} \text{ mm}$$

P_1 = corrected patch load obtained from Table 4.3.4

k = material factor, see Ch 2,1.2

α = thickness coefficient obtained from Fig. 4.3.1

β = tyre print coefficient used in Fig. 4.3.1

$$= \log_{10} \left(\frac{P_1 k^2}{s^2} \times 10^7 \right)$$

s = spacing, in mm of frames, beams or longitudinals, as appropriate.

3.3.5 Where a transversely framed deck contributes to the hull girder strength or where secondary stiffening is fitted perpendicular to the direction of vehicle lanes, the thickness, t , derived from 3.3.4 is to be increased by 1,0 mm.

3.3.6 Where it is proposed to carry tracked vehicles, the patch dimensions may be taken as the track print dimensions and P_w is to be taken as half the total weight of the vehicle. The wear and wastage allowance, t_c , is to be increased by 0,5 mm.

3.3.7 Deck fittings in way of vehicle lanes are to be recessed.

Pontoons

Part 3, Chapter 4

Section 3

Table 4.3.2 Side and end shell plating

Location	Thickness, in mm	
	Longitudinal framing	Transverse framing
(1) Side shell clear of sheerstrake	(a) Above $\frac{D}{2}$ from base: The greater of the following: (i) $t = \frac{0,001s_1 (0,059L + 7)}{\sqrt{k}}$ (ii) $t = 0,0042s_1 \sqrt{h_{T1} k}$	(a) Above $\frac{D}{4}$ from the gunwale: The greater of the following: (i) $t = \frac{0,00085s_1 f_1 (0,083L_1 + 10)}{\sqrt{k}}$ (ii) $t = 0,0042s_1 \sqrt{h_{T1} k}$
	(b) Up to $\frac{D}{2}$ from base: The greater of the following: (i) $t = \frac{0,001s_1 (0,059L + 7)}{\sqrt{k}}$ (ii) $t = 0,0054s_1 \sqrt{h_{T2} k}$	(b) Within $\frac{D}{4}$ from mid-depth: (i) $t = \frac{0,001s_1 (0,059L + 7)}{\sqrt{k}}$ (ii) $t = 0,0051s_1 \sqrt{h_{T1} k}$
		(c) Within $\frac{D}{4}$ from base (i) $t = \frac{0,00085s_1 f_1 (0,083L + 10)}{\sqrt{k}}$ (ii) $t = 0,00626s_1 \sqrt{h_{T2} k}$
Symbols		
L, D as defined in 1.3 L_1 as defined in Fig. 4.1.1 k = material factor see Ch 2,1.2 C_w = wave head, in metres $= 7,71 \times 10^{-2} L \cdot e^{-0,0044L}$ where e is the base of natural logarithms 2,71828 $f_1 = \frac{1}{1 + \left(\frac{s}{1000S}\right)^2}$		
$h_{T1} = T + C_w$ m but need not be taken greater than 1,36T $h_{T2} = T + 0,5C_w$ m but need not be taken greater than 1,2T $s_1 = s$, but is not to be taken less than the smaller of $470 + \frac{L}{0,6}$ mm or 700 mm s = spacing of frames, beams or longitudinals, in mm		

Pontoons

Part 3, Chapter 4

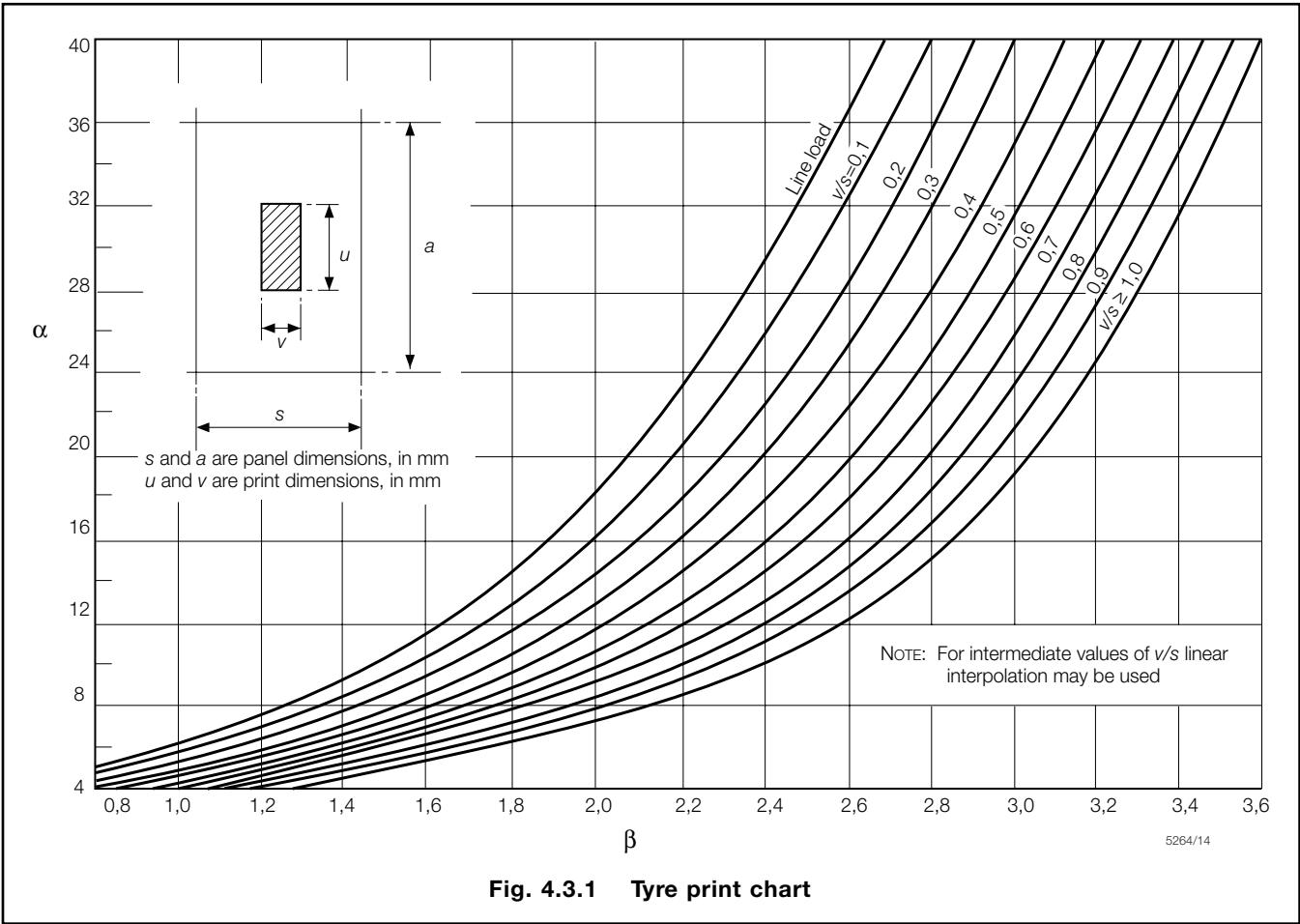
Section 3

Table 4.3.3 Strength/weather deck plating

Location	Minimum thickness, in mm	
	Longitudinal framing	Transverse framing
(1) Deck plating	<p>The greater of the following:</p> <p>(a) $t = \frac{0,001s_1 (0,059L + 7)}{\sqrt{k}}$</p> <p>(b) $t = 0,00083s_1\sqrt{Lk} + 2,5$</p>	<p>The greater of the following:</p> <p>(a) $t = \frac{0,001s_1 f_1 (0,083L + 10)}{\sqrt{k}}$</p> <p>(b) $t = 0,001s_1\sqrt{Lk} + 2,5$</p>
(2) In way of the crown of a tank	$t = 0,004s f \sqrt{\frac{\rho k h_4}{1,025}} = 3,5$ <p>or as (1) whichever is the greater, but not less than 6,5 mm</p>	
Symbols		
<p>L as defined in 1.3</p> <p>ρ = relative density (specific gravity) of liquid carried in a tank, but is not to be taken less than 1,025</p> <p>k = material factor see Ch 2,1.2</p> <p>s = spacing of frames, beams or longitudinals, in mm</p> <p>S = spacing or mean spacing of girders, transverses or floors, in metres</p> <p>f = $1,1 - \frac{C}{2500 S}$ but not to be taken greater than 1,0</p> <p>$f_1 = \frac{1}{1 + \left(\frac{s}{1000S}\right)^2}$</p> <p>$h_4$ = tank head, in metres, see Table 4.5.1</p> <p>$s_1 = s$, but is not to be taken less than the smaller of $470 + \frac{L}{0,6}$ mm or 700 mm</p>		

Table 4.3.4 Corrected patch loading

Symbols	Expression
<p>$a, s, u,$ and v as defined in Fig. 4.3.1</p> <p>P_w = load, in tonnes, on the tyre print. For closely spaced wheels the shaded area shown in Fig. 4.3.1 may be taken as the combined print</p> <p>P_1 = corrected patch load, in tonnes</p> <p>λ = dynamic magnification factor</p> <p>ϕ_1 = patch aspect ratio correction factor</p> <p>ϕ_2 = panel aspect ratio correction factor</p> <p>ϕ_3 = wide patch load factor</p>	$P_1 = \phi_1 \phi_2 \phi_3 \lambda P_w$
	$\phi_1 = \frac{2v_1 + 1,1s}{u_1 + 1,1s}$ <p>$v_1 = v$, but $\nless s$ $u_1 = u$, but $\nless a$</p>
	$\phi_2 = 1,0$ for $u \leq (a - s)$ $= \frac{1}{1,3 - \frac{0,3}{s}(a - u)}$ for $a \geq u > (a - s)$ $= 0,77 \frac{a}{u}$ for $u > a$
	$\phi_3 = 1,0$ for $v < s$ $= 0,6 \frac{s}{v} + 0,4$ for $1,5 > \frac{v}{s} \geq 1,0$ $= 1,2 \frac{s}{v}$ for $\frac{v}{s} \geq 1,5$
	$\lambda = 1,25$



Section 4
 Hull envelope framing

4.1 General

- 4.1.1 Bottom, side and deck transverses are to be connected in such a manner as to ensure continuity of the transverse ring system, and longitudinals are to be attached to transverses. In way of deck and bottom transverses, a deep web frame may be required to be fitted.
- 4.1.2 End connections of longitudinals at bulkheads are to provide adequate fixity and continuity of longitudinal strength.
- 4.1.3 Brackets at the top and bottom of side frames are to extend to the deck and bottom longitudinals to which they are to be attached.
- 4.1.4 In pontoons where truss arrangements, comprising top and bottom girders in association with pillars and diagonal bracing, are used in the support of the deck loads, the diagonal members are generally to have angles of inclination with the horizontal of about 45° and cross-sectional area of at least 50 per cent of the adjacent pillar in accordance with Section 6.

4.1.5 Adequate support is to be provided for the loads imposed on the structure when the pontoon is in dry-dock.

4.2 Longitudinal framing

4.2.1 The scantlings of bottom, side and deck longitudinals are to comply with the requirements of Table 4.4.1.

Table 4.4.1 Longitudinal framing

Position of longitudinals	Modulus, in cm ³
Bottom	$Z = 11,0 k l_e^2 s h \times 10^{-3}$
Side and end shell	$Z = 8,0 k l_e^2 s h \times 10^{-3}$
Deck	$Z = 5,5 k l_e^2 s h \times 10^{-3}$
Symbols	
<i>h</i> as defined in 1.3.5	
<i>Z</i> = section modulus of stiffening member, in cm ³ , see Pt 3, Ch 3,2	
<i>l_e</i> = effective length of stiffening member, in metres, see Pt 3, Ch 3,2	
<i>s</i> = spacing of frames, beams, or longitudinals, in mm	
<i>k</i> = material factor see Ch 2,1.2	

Pontoons

Part 3, Chapter 4

Section 4

4.2.2 In addition, the following requirements for depth to thickness ratios of longitudinals are to be met:

(a) Flat bar longitudinal:

(i) when continuous at bulkheads

$$\frac{d_w}{t_w} \leq 18 \sqrt{k}$$

(ii) when non-continuous at bulkheads

$$\frac{d_w}{t_w} \leq 15 \sqrt{k}$$

(b) Built sections

(i) $\frac{d_w}{t_w} \leq 60 \sqrt{k}$

(ii) $\frac{b_f}{t_f} \leq 15$ for asymmetric sections

(iii) $\frac{b_f}{t_f} \leq 30$ for symmetric sections

where

k = material factor, see Ch 2,1.2

d_w = depth of web, in mm

t_w = thickness of web, in mm

b_f = width of face plate, in mm

t_f = thickness of face plate, in mm.

4.3 Transverse framing

4.3.1 The scantlings of bottom and side frames and deck beams are to comply with the requirements of Table 4.4.2.

Table 4.4.2 Transverse framing

Position of member	Modulus, in cm ³
Bottom and side frames	$Z = 9,5 k l_e^2 s h \times 10^{-3}$
Deck beams	$Z = 4,5 k l_e^2 s h \times 10^{-3}$
Symbols	
<p>h as defined in 1.3.5</p> <p>Z = section modulus of stiffening member, in cm³, see Ch 3,2</p> <p>l_e = effective length of stiffening member, in metres, see Ch 3,2</p> <p>s = spacing of frames, beams, or longitudinals, in mm</p> <p>k = material factor, see Ch 2,1.2</p>	

4.4 Primary supporting structure

4.4.1 Primary supporting members are to comply with the requirements of Table 4.4.3.

Table 4.4.3 Primary supporting structure

Position of member	Modulus, in cm ³
Bottom transverse	$Z = 11,0 k l_e^2 S h$
Side transverse	$Z = 8,0 k l_e^2 S h$
Deck transverse	$Z = 5,5 k l_e^2 S h$
Bottom girder	$Z = 9,5 k l_e^2 S h$
Deck longitudinal girder	$Z = 5,0 k l_e^2 S h$
Symbols	
<p>h as defined in 1.3.5</p> <p>Z = section modulus of stiffening member, in cm³, see Ch 3,2</p> <p>l_e = effective length of stiffening member, in metres, see Ch 3,2</p> <p>S = spacing or mean spacing of girders, transverses or floors, in metres</p> <p>k = material factor see Ch 2,1.2</p>	

4.5 Deck beams and longitudinals subject to vehicle loading

4.5.1 The section modulus, Z , of deck beams or longitudinals is to be not less than that required to satisfy the most severe arrangement of print wheel loads on the stiffener in association with a bending stress of:

$$\frac{100}{k} \text{ N/mm}^2 \text{ assuming 100 per cent end fixity.}$$

where

k = material factor, see Ch 2,1.2.

4.6 Deck girders and transverses subject to vehicle loading

4.6.1 Where the load on deck girders and transverses is uniformly distributed, the section modulus is to be not less than:

$$Z = 4,75 b h l_e^2 k \text{ cm}^3$$

where

h is defined in 1.3.5

l_e = effective length of stiffening member, in metres, see Ch 3,2

b = mean width of plating supported by a deck girder or transverse, in metres

k = material factor, see Ch 2,1.2.

4.6.2 Where the member supports point loads, with or without the addition of uniformly distributed load, the section

modulus is to be based on a stress of $\frac{123,6}{k} \text{ N/mm}^2$

assuming 100 per cent end fixity

where

k = material factor, see Ch 2,1.2.

Pontoons

Part 3, Chapter 4

Sections 4 & 5

4.6.3 Where it is proposed to carry tracked vehicles, the total weight of the vehicle is to be taken when determining the section modulus of the transverse at the top of a ramp or at other changes of gradient.

4.7 Direct calculations

4.7.1 As an alternative to 4.5 and 4.6, permissible deck load capacity may be determined by direct calculation.

4.8 Ship ramp loads

4.8.1 The deck plating and underdeck stiffening are to be considered for any loads imposed by ship ramps, where appropriate.

4.9 Train decks

4.9.1 Decks for the transport of railway rolling stock on fixed rails will be specially considered.

4.10 Heavy or special loads

4.10.1 Where heavy or special loads, such as machinery transporters are proposed to be carried, the scantlings and arrangements of the deck structure will be individually considered.

5.2.3 The watertight bulkheads are to be the full depth of the pontoon and are to provide support for the weather and vehicle deck.

5.2.4 Watertight recesses or doors in bulkheads are generally to be so framed and stiffened as to provide strength and stiffness equivalent to the requirements for watertight bulkheads.

5.2.5 Any machinery spaces inside pontoons are to be protected by watertight bulkheads.

5.3 Watertight and ballast tank bulkheads

5.3.1 The scantlings of watertight and ballast tank bulkheads are to comply with the requirements of Table 4.5.1.

5.3.2 Where bulkhead stiffeners support deck girders, transverses or pillars over, they are also to satisfy the requirements of Table 4.5.1.

5.3.3 Where watertight bulkhead stiffeners are cut in way of watertight doors in the lower part of a bulkhead, the opening is to be suitably framed and reinforced. Where stiffeners are not cut but the spacing between the stiffeners is increased on account of watertight doors, the stiffeners at the sides of the doorways are to be increased in depth and strength so that the efficiency is at least equal to that of the unpierced bulkhead, without taking the stiffness of the door frame into consideration. Watertight recesses in bulkheads are generally to be so framed and stiffened as to provide strength and stiffness equivalent to the requirements for watertight bulkheads.

■ Section 5 Bulkheads

5.1 General

5.1.1 These requirements cover watertight and ballast tank transverse and longitudinal bulkheads. Requirements are also given for non-watertight pillar bulkheads.

5.1.2 The requirements apply to a vertical system of stiffening on bulkheads. They may also be applied to a horizontal system of stiffening provided that equivalent end support and alignment are provided.

5.2 Number and disposition of bulkheads

5.2.1 All pontoons ($L \leq 30$ m) are to be subdivided by at least two transverse watertight bulkheads and one watertight longitudinal bulkhead. For pontoons where $30 \text{ m} < L \leq 65$ m, at least three transverse watertight bulkheads and one longitudinal watertight bulkhead, or two transverse and two longitudinal watertight bulkheads are to be fitted.

5.2.2 The bulkheads are to be spaced at reasonably uniform intervals.

Pontoons

Part 3, Chapter 4

Section 5

Table 4.5.1 Watertight and ballast tank bulkhead scantlings

Item and requirement	Watertight bulkhead	Ballast tank bulkhead
(1) Plating thickness for plane, symmetrical corrugated and double plate bulkheads	$t = 0,004s f \sqrt{h_4 k} \text{ mm}$ <p>but not less than 5,5 mm</p>	$t = 0,004s f \sqrt{\frac{\rho h_4 k}{1,025}} + 2,5 \text{ mm}$ <p>but not less than 6,5 mm</p>
	In the case of symmetrical corrugations, s is to be taken as b or c in Fig. 3.2.1 in Ch 3,2 whichever is the greater	
(2) Modulus of rolled and built stiffeners, swedges, double plate bulkheads and symmetrical corrugations	$Z = \frac{s k h_4 l_e^2}{284 \gamma} \text{ cm}^3$	$Z = \frac{\rho s k h_4 l_e^2}{88 \gamma} \text{ cm}^3$
	In the case of symmetrical corrugations, s is to be taken as p, see also Note 2	
(3) Inertia of rolled and built stiffeners and swedges	—	$I = \frac{2,3}{k} l_e Z \text{ cm}^4$
(4) Symmetrical corrugations and double plate bulkheads	Additional requirements to be complied with as detailed in Table 4.5.2	
(5) Stringers or webs supporting vertical or horizontal stiffening		
(a) Modulus	$Z = 5,5 k h_4 S l_e^2 \text{ cm}^3$	$Z = 11,7 \rho k h_4 S l_e^2 \text{ cm}^3$
(b) Inertia	—	$I = \frac{2,3}{k} l_e Z \text{ cm}^4$
Symbols		
<p>s, S, k as defined in Table 4.3.3</p> <p>d_w = web depth of stiffening member, in mm</p> <p>$f = 1,1 - \frac{s}{2500S}$ but not to be taken greater than 1,0</p> <p>h_4 = load head, in metres, measured vertically as follows:</p> <p>(a) For watertight bulkhead plating, the distance from a point one-third of the height of the plate above its lower edge to a point 0,91 m above the bulkhead deck at side</p> <p>(b) For ballast tank bulkhead plating, the distance from a point one-third of the height of the plate above its lower edge to the top of the tank, or half the distance to the top of the overflow, whichever is the greater</p> <p>(c) For watertight bulkhead stiffeners or girders, the distance from the middle of the effective length to a point 0,91 m above the bulkhead deck at side</p> <p>(d) For ballast tank bulkhead stiffeners or girders, the distance from the middle of the effective length to the top of the tank, or half the distance to the top of the overflow, whichever is the greater</p> <p>l_e = effective length of stiffening member, in metres</p> <p>ρ = spacing of corrugations as shown in Chapter 3, Fig. 3.2.1</p> <p>γ = 1,4 for rolled or built sections and double plate bulkheads</p> <p>= 1,6 for flat bars</p> <p>= 1,1 for symmetrical corrugations of ballast tank bulkheads</p> <p>= 1,0 for symmetrical corrugations of watertight bulkheads</p>		
NOTES		
1. In no case are the scantlings of ballast tank bulkheads to be less than the requirements for watertight bulkheads.		
2. In calculating the actual modulus of symmetrical corrugations the panel width b, is not to be taken greater than that given by Ch 3,2.1.		
3. For rolled or built stiffeners with flanges or face plates, the web thickness is to be not less than $\frac{d_w}{60 \sqrt{k}}$ whilst for flat bar stiffeners the web thickness is to be not less than $\frac{d_w}{18 \sqrt{k}}$		

5.4 Corrugated and double plated bulkheads

5.4.1 Where corrugated and double plated bulkheads are fitted in pontoons the additional requirements of Table 4.5.2 are to be met.

5.5 Non-watertight pillar bulkheads

5.5.1 The scantlings of non-watertight pillar bulkheads are to comply with the requirements of Table 4.5.3.

Pontoons

Part 3, Chapter 4

Section 5

Table 4.5.2 Symmetrical corrugations and double plate bulkheads (additional requirements)

Symbols	Type of bulkhead	Parameter	Watertight bulkheads	Ballast tank bulkheads
s, k as defined in Table 4.3.3 b = panel width as in Pt 3, Ch 3.2.1.4 d = depth, in mm, of symmetrical corrugation or double plate bulkhead l_e as defined in Ch 3.2.2 A_w = shear area, in cm ² of web of double plate bulkhead θ = angle of web corrugation to plane of bulkhead	Symmetrically corrugated (see also Notes 1 and 2)	$\frac{b}{t}$	Not to exceed: 85 \sqrt{k} at top, and 70 \sqrt{k} at bottom	Not to exceed: 70 \sqrt{k} at top, and at bottom
		d	—	To be not less than 39 l_e mm
		θ	To be less than 40°	
NOTES 1. The plating thickness at the middle of span l_e of corrugated or double plate bulkheads is to extend not less than 0,2 l_e m above mid-span. 2. Where the span of corrugations exceeds 15 m, a diaphragm plate is to be arranged at about mid-span.	Double plate	$\frac{s}{t}$	Not to exceed: 75 \sqrt{k} at top, and 65 \sqrt{k} at bottom	
		$\frac{d}{t_w}$	Not to exceed: 85 \sqrt{k} at top, and 75 \sqrt{k} at bottom	
		d	—	To be not less than 39 l_e mm
		A_w	Not to exceed: $\frac{0,12Z}{l_e}$ cm ² at top and $\frac{0,18Z}{l_e}$ cm ² at bottom	Not to exceed: $\frac{0,07Z}{l_e}$ cm ² at top and $\frac{0,10Z}{l_e}$ cm ² at bottom

5.6 Storage of flammable liquid

5.6.1 Pontoon tanks used for the storage of flammable liquid are to have at least a one tank or dry space separation from the ship interface.

Pontoons

Part 3, Chapter 4

Sections 5 & 6

Table 4.5.3 Non-watertight pillar bulkhead

Symbols	Parameter	Requirement
d_w, t_p, b, c as defined in Pt 3, Ch 3,2 r = radius of gyration, in mm, of stiffener and attached plating $= 10 \sqrt{\frac{I}{A}}$ for rolled built or swaged stiffeners $= d_w \sqrt{\frac{3b+c}{12(b+c)}}$ for symmetrical corrugation I = moment of inertia, in cm ⁴ , of stiffener and attached plating s = spacing of stiffeners, in mm A = cross-sectional area, in cm ² , of stiffener and attached plating $A_1 = \frac{P}{12,36 - 51,5 \frac{l_e}{r}} \text{ cm}^2$ As a first approximation A_1 may be taken as $\frac{P}{9,32}$ $A_2 = \frac{P}{4,9 - 14,7 \frac{l_e}{r}} \text{ cm}^2$ As a first approximation A_2 may be taken as $\frac{P}{9,32}$ P, l_e as defined in Table 4.6.1 $\lambda = \frac{b}{c}$	(1) Minimum thickness of bulkhead plating	5,5 mm
	(2) Maximum stiffener spacing	1500 mm
	(3) Minimum depth of stiffeners or corrugations	100 mm
	(4) Cross-section area (including plating) for rolled, built or swaged stiffeners supporting beams, longitudinals, girders or transverses	(a) Where $\frac{s}{t} \leq 80$ $A = A_1$ (b) Where $\frac{s}{t} \geq 120$ $A = A_2$ (c) Where $80 < \frac{s}{t} < 120$ A is obtained by interpolation between A_1 and A_2
		(a) Where $\frac{b}{t_p} \leq \frac{750 \lambda l_e}{(\lambda + 0,25) r}$ $A = A_1$ (b) Where $\frac{b}{t_p} \leq \frac{750 \lambda l_e}{(\lambda + 0,25) r}$ $A = A_2$
	(5) Cross-sectional area (including plating) for symmetrical corrugations	

Section 6 Pillars

6.1 General

6.1.1 Pillars are to comply with the requirements of Table 4.6.1.

6.1.2 Pillars are to be fitted in the same vertical line wherever possible and effective arrangements are to be made to distribute the load at the ends of all pillars. Where pillars support eccentric loads, they are to be strengthened for the additional bending moment imposed upon them.

6.1.3 Pillars of hollow section are to be attached at their heads to plates supported by efficient brackets, in order to transmit the load effectively. Doubling or insert plates are to be fitted to the inner bottom under the heels of hollow pillars, and to decks under large pillars. The pillars are to have a bearing fit and are to be attached to the head and heel plates by continuous welding. At the ends of pillars built of rolled open sections, the load is to be well distributed by means of longitudinal and transverse brackets.

6.1.4 Where pillars are fitted inside tanks the tensile stress in the pillar and its end connections is not to exceed 108 N/mm² at the test heads. In general, such pillars should be of fabricated sections, and end brackets may be required.

Table 4.6.1 Pillars

Symbols	Parameter	Requirement
b = breadth of side of a hollow rectangular pillar or breadth of flange or web of a built or rolled section, in mm d_p = mean diameter of tubular pillars, in mm k = material factor l = overall length of pillar, in metres l_e = effective length of pillar, in metres l_p = distance, in metres, between centres of the two adjacent spans of girder, or transverse, supported by the pillar P_a = load, in kN, from pillar or pillars above (zero if no pillars over) r = least radius of gyration of a pillar cross-section, in mm, and may be taken as $r = 10 \sqrt{\frac{I}{A_p}} \text{ mm}$ A_p = cross-sectional area of pillar, in cm ² S as defined in Table 4.3.3 H_g is defined as the equivalent sea water head from distributed design loads including, vehicles, passengers, ramp loads or ship's ramp load or any combination of these, but is not to be taken less than $0,01L + 0,7 \text{ m}$ I = least moment of inertia of cross-section, in cm ⁴ P = load, in kN, supported by the pillar and is to be taken as $10,06 S H_g l_p + P_a$ but not less than 19,62 kN For pillars loaded by concentrated loads from ramps or other structures above, P is to be individually calculated, in kN, for the loads involved including distributed loads	(1) Cross-sectional area of all types of pillar	$A_p = \frac{k P}{12,36 - 51,5 \frac{l_e}{r \sqrt{k}}}$ See Note
	(2) Minimum wall thickness of tubular pillars	The greatest of the following: (a) $t = \frac{P}{0,392 d_p - 4,91 l_e} \text{ mm}$ (b) $t = \frac{d_p}{40} \text{ mm}$ (c) $t = 5,5 \text{ mm}$
	(3) Minimum wall thickness of hollow rectangular pillars or web plate thickness of I or channel sections	The lesser of the following: (a) $t = \frac{b r}{600 l_e} \text{ mm}$ (b) $t = \frac{b}{55} \text{ mm}$ But not less than $t = 5,5 \text{ mm}$
	(4) Minimum thickness of flanges of angle or channel sections	The lesser of the following: (a) $t_f = \frac{b r}{200 l_e} \text{ mm}$ (b) $t_f = \frac{b}{18} \text{ mm}$
	(5) Minimum thickness of flanges of built or rolled I sections	The lesser of the following: (a) $t_f = \frac{b r}{400 l_e} \text{ mm}$ (b) $t_f = \frac{b}{36} \text{ mm}$

NOTE

As a first approximation A_p may be taken as $\frac{\sqrt{k} P}{9,32}$ and the radius of gyration estimated for a suitable section having this area.

If the area calculated using this radius of gyration differs by more than 10 per cent from the first approximation, a further calculation using the radius of gyration corresponding to the mean area of the first and second approximation is to be made.

Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Sections 1, 2 & 3

Section

- 1 **General**
- 2 **Materials**
- 3 **Design loads and combinations**
- 4 **Design criteria**

■ Section 1 General

1.1 Application

1.1.1 This Chapter provides the strength requirements for bridges and ramps, used for the carriage of vehicles between ship and shore, and their support structures.

1.1.2 The bridges and ramps may span between:

- (a) the quay-side and a pontoon;
 - (b) the quay-side and a non-buoyant means of support (e.g. gantry);
 - (c) a pontoon and the berthed ship;
 - (d) the quay-side and the berthed ship;
- or may be entirely supported by a pontoon or two non-buoyant supports.

1.2 Objective

1.2.1 The scantlings and supporting arrangements are to be consistent with the method of support, the environmental conditions prevailing at the operating location, the berthing conditions and the specified vehicle loading data.

1.2.2 Bridges, ramps and their bearings are to be suitably designed to accommodate, where applicable, the effects of a static support at one end and a dynamic support at the other.

1.2.3 Consideration is to be given to the proposed frequency of use, including the frequency of ferry berthings and the number of vehicles using the bridges and ramps.

1.3 Basis of structural design

1.3.1 The adequacy of the structural components in this chapter is assessed on the basis of an allowable stress and factored load approach.

1.4 Information required for approval

1.4.1 See general note on Information to be submitted for approval in Ch 1,8.

■ Section 2 Materials

2.1 General requirements

2.1.1 The materials used in the construction of bridges and ramps, including their support and restraint arrangements and any movable extensions, are to comply where applicable, with the requirements of *Rules for the Manufacture, Testing and Certification of Materials*.

■ Section 3 Design loads and combinations

3.1 General

3.1.1 When loaded, all bridges and ramps are to be considered for the worst possible in-service combination of loads, inclinations, and support arrangements arising from the following forces:

- (a) Self-weight.
- (b) Applied vehicle loadings.
- (c) Dynamic forces due to vehicle movement including braking, skidding and cornering effects.
- (d) Static and dynamic forces due to inclination, twist and movement of the pontoon or other buoyant support.
- (e) Operational environmental loads (e.g. wind, wave and current), including those acting on a berthed ship which can be transferred to the linkspan structure.
- (f) Forces transferred to the linkspan due to motions of the berthed ship.

3.1.2 When unloaded and out-of-service all bridges and ramps are to be considered for the worst possible combination of loads, angles and support arrangements arising from the following forces:

- (a) Self-weight.
- (b) Static and dynamic forces due to inclination and movement of the pontoon or other buoyant support.
- (c) Extreme environmental loads (e.g. wind, wave and current) appropriate to the location.

3.1.3 For raising or slewing manoeuvres the bridges and ramps are to be considered with respect to the following forces:

- (a) Self-weight.
- (b) Dynamic forces due to hoisting/slewing.
- (c) Static and dynamic forces due to inclination and movement of the pontoon or other buoyant support.
- (d) Environmental loads.
- (e) Loads due to ship motions transmitted through any ship to linkspan connection, as appropriate.

3.2 Basic load factors

3.2.1 The self-weight load, L_w , is to be taken as the weight of the ramp or bridge for all design conditions, except when it is being mechanically raised or lowered, in which case it is to be multiplied by a dynamic factor of 1,1.

Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Sections 3 & 4

3.2.2 The applied load, L_c , is the static load on the ramp or bridge due to vehicles and is to be multiplied by a factor of 1,1 to take account of vehicle movement.

3.2.3 Environmental loads, L_e , need not be multiplied by any factor.

3.2.4 HA and HB vehicle loading already contain an allowance for impact and need not be further factored.

3.3 Forces due to motion of the pontoon or other buoyant support

3.3.1 Ramps and bridges are to be designed to operate safely and efficiently when accommodating any inclination or dynamic movement of the pontoon or other buoyant structure from which they derive their support.

3.4 Load combinations

3.4.1 Ramps and bridges are to be considered for the design loadings resulting from the following load cases:

- Case 1: Loaded operational-in service condition.
- Case 2: Unloaded, out of service, survival condition.
- Case 3: Manoeuvring condition when unloaded (if appropriate), i.e. when being mechanically hoisted or lowered.

Case 1. The bridge or ramp is to be considered with respect to self weight plus the applied load multiplied by 1,1, together with any horizontal, vertical and rotational forces resulting from pontoon movement and slope of the bridge/ramp, together with any loads imposed by the ship and any environmental loading. This is represented by the following expression:

$$L_w + 1,1L_{VV} + L_{VP} + L_{HP} + L_{RP} + L_{VH} + L_e + L_{SR} + L_s$$

where the above loads are added vectorially, and where:

L_w = self weight load

L_{VV} = applied vehicular load normal to deck

L_{VP} = vertical force from pontoon movement

L_{HP} = horizontal force from pontoon movement

L_{RP} = rotational forces from pontoon movement

L_{VH} = load due to slope of bridge/ramp including braking or skidding loads

L_e = environmental loads as appropriate

L_{SR} = load from ship's ramp

L_s = loads due to ship movement transmitted through any ship to linkspan connection

Case 2. The bridge or ramp is to be considered with respect to the direct forces resulting from the extreme environmental conditions (generally 1 in 50 year return case) and from the corresponding forces acting on the self weight resulting from the accelerations due to pontoon motions and static inclination resulting from the same severe environmental conditions.

Case 3. The bridge or ramp is to be considered with respect to its self weight multiplied by 1,1 together with any additional vertical, horizontal and rotational forces resulting from pontoon motions, see 3.3.1.

For ramps which are unloaded during manoeuvring this is represented by the following expression:

$$1,1L_w + L_{VP} + L_{HP} + L_{RP}$$

where the above loads are added vectorially.

Section 4 Design criteria

4.1 Allowable stress – Elastic failure

4.1.1 The allowable stress, σ_a , is to be taken as the failure stress of the component concerned multiplied by a stress factor, F , which depends on the load case considered. The allowable stress is given by the general expression:

$$\sigma_a = F\sigma \text{ or } \tau_a = F\tau$$

where

σ_a = allowable direct stress, in N/mm²

τ_a = allowable shear stress, in N/mm²

F = stress factor

σ, τ = failure stress, in N/mm².

4.1.2 The stress factors, F , for steels in which $\frac{\sigma_y}{\sigma_u} \leq 0,7$ where

σ_y = yield stress of material, in N/mm²

σ_u = ultimate tensile stress of the material, in N/mm² are given in Table 5.4.1.

Table 5.4.1 Stress factor, F

Load case	1	2	3
Stress factor, F	0,60	0,85	0,6

4.1.3 For steel with $\frac{\sigma_y}{\sigma_u} > 0,7$ the allowable stress is to be derived from the following expression:

$$\sigma_a = 0,41F(\sigma_u + \sigma_y)$$

$$\tau_a = 0,24F(\sigma_u + \sigma_y)$$

where

σ_a and τ_a are defined in 4.1.1.

4.1.4 The failure stress for the elastic modes of failure are given in Table 5.4.2.

Table 5.4.2 Failure stress

Mode of failure	Symbol	Failure stress
Tension	σ_t	$1,0\sigma_y$
Compression	σ_c	$1,0\sigma_{cr}$
Shear	τ	$0,58\sigma_y$
Bearing	σ_{br}	$1,0\sigma_y$

Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Section 4

4.1.5 For components subjected to combined stresses the following allowable stress criteria are to be used:

- (a) $\sigma_{xx} < F\sigma_t$
- (b) $\sigma_{yy} < F\sigma_t$
- (c) $\tau_o < F\tau$
- (d) $\sigma = (\sigma_{xx}^2 + \sigma_{yy}^2 - \sigma_{xx}\sigma_{yy} + 3\tau_o^2)^{1/2} \leq 1,1F\sigma_t$

where

- σ_{xx} = applied stress in x direction, in N/mm²
- σ_{yy} = applied stress in y direction, in N/mm²
- τ_o = applied shear stress, in N/mm².

4.2 Allowable stress – Compression and bending members

4.2.1 The allowable axial stress for compression members is to be taken as the critical compressive stress, σ_{cr} , multiplied by the allowable stress factor, F , as defined in Table 5.4.1.

4.2.2 For members subjected to simple compression the critical compression stress is given by the Perry-Robertson formula below:

$$\sigma_{cr} = \frac{\sigma_y + (1 + \eta) \sigma_e}{2} - \sqrt{\left(\frac{\sigma_y + (1 + \eta) \sigma_e}{2}\right)^2 - (\sigma_e \cdot \sigma_y)}$$

where

$$\sigma_e = \frac{\pi^2 \cdot E}{\left(\frac{Kl}{r}\right)^2}$$

$$\eta = 0,001a \left(\frac{Kl}{r} - 0,2\pi \sqrt{\frac{E}{\sigma_y}} \right)$$

E = Young's modulus, in N/mm²

l = length, in mm

r = radius of gyration, in mm

a = Robertson's constant as per Table 5.4.3

σ_y = yield stress, in N/mm²

K = constant dependent on the end constraint condition of the member as per Table 5.4.4.

4.2.3 For members subjected to combined bending and compression the following stress criteria are to be used:

$$\frac{\sigma_{bx} + \sigma_{by}}{\sigma_t} + \frac{\sigma_c}{\sigma_{cr}} < F$$

where

σ_{bx} = applied bending stress about the X-X axis, in N/mm²

σ_c = applied compression stress, in N/mm²

σ_{by} = applied bending stress about the Y-Y axis, in N/mm².

4.3 Allowable stress – Plate buckling failure

4.3.1 The allowable stress is to be taken as the critical buckling stress σ_{cb} , σ_{bb} , or τ_b as appropriate of the component concerned multiplied by the stress factor, F , as defined in Table 5.4.1.

4.3.2 For components subject to compression the critical buckling stress is given by:

(a) for $\sigma_{cb} < 0,5\sigma_y$

$$\sigma_{cb} = K_c E \left(\frac{t}{b} \right)^3$$

(b) for $\sigma_{cb} \geq 0,5\sigma_y$

$$\sigma_{cb} = \sigma_y \left(1 - \frac{\sigma_y}{4K_c E \left(\frac{t}{b} \right)^2} \right)$$

where

σ_{cb} = critical compression buckling stress, in N/mm²

K_c = compression buckling constant, see Fig. 5.4.1

E = Young's modulus, in N/mm²

t = plate thickness, in mm

b = plate width, i.e. normal to direction of stress, in mm.

4.3.3 For components subject to shear, the critical buckling stress is given by:

(a) for $\tau_b < 0,29\sigma_y$

$$\tau_b = K_s E \left(\frac{t}{b} \right)^2$$

(b) for $\tau_b \geq 0,29\sigma_y$

$$\tau_b = 0,58\sigma_y \left(1 - \frac{0,58\sigma_y}{4K_s E \left(\frac{t}{b} \right)^2} \right)$$

where

τ_b = critical shear buckling stress, in N/mm²

K_s = shear buckling constant, see Fig. 5.4.2

E = Young's modulus, in N/mm²

t = plate thickness, in mm

b = smallest plate dimension, in mm.

4.3.4 For components subject to bending stress the critical buckling stress is given by:

(a) for $\sigma_{bb} < 0,5\sigma_y$

$$\sigma_{bb} = K_b E \left(\frac{t}{b} \right)^2$$

(b) for $\sigma_{bb} \geq 0,5\sigma_y$

$$\sigma_{bb} = \sigma_y \left(1 - \frac{\sigma_y}{4K_b E \left(\frac{t}{b} \right)^2} \right)$$

where

σ_{bb} = critical buckling stress, in N/mm²

K_b = bending buckling constant, see Fig. 5.4.3

E = Young's modulus, in N/mm²

t = plate thickness, in mm

b = plate width, i.e. normal to direction of stress, in mm.

4.3.5 For components subject to combined compression and shear, the following allowable stress criteria are to be met:

(a) $\sigma_c < F\sigma_{cb}$

(b) $\tau < F\tau_b$

(c) $\frac{\sigma_c}{\sigma_{cb}} + \left(\frac{\tau}{\tau_b} \right)^2 < F$

τ = applied shear stress, in N/mm².

Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Section 4

Table 5.4.3 Values of Robertson Constant, a , for various sections

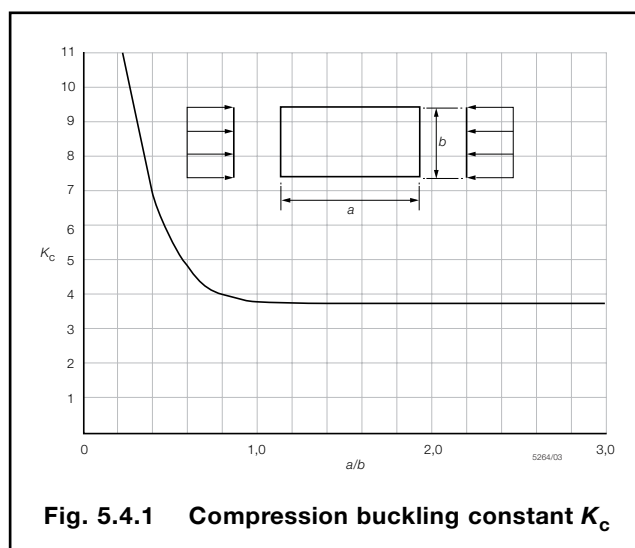
Type of section	Thickness of flange or plate, in mm	Axis of buckling	a
Rolled I section (universal beams)		xx	2,0
		yy	3,5
Rolled H section (universal columns) See Note 1	up to 40	xx	3,5
		yy	5,5
	over 40	xx	5,5
		yy	8,0
Welded plate I or H sections See Notes 1, 2 and 3	up to 40	xx	3,5
		yy	5,5
	over 40	xx	3,5
		yy	8,0
Rolled I or H section with welded flange cover plates See Notes 1 and 4		xx	3,5
		yy	
		xx	2,0
		yy	
Welded box sections See Notes 1,3 and 4	up to 40	any	3,5
	over 40	any	5,5
Rolled channel sections, rolled angle sections and T-bars (rolled or cut from universal beam or column)		any	5,5
Hot-rolled structural hollow sections		any	2,0
Rounds, square and flat bars See Note 1	up to 40	any	3,5
	over 40	any	5,5
Compound rolled sections (2 or more I, H or channel sections, I section plus channel, etc.)		any	5,5
Two rolled angle, channel or T-sections, back-to-back		any	5,5
Two rolled sections laced or battened		any	5,5
Lattice strut		any	2,0

NOTES

- For thicknesses between 40 mm and 50 mm the value of σ_{cb} , τ_b or σ_{bb} may be taken as the average of the value for thicknesses less than 40 mm and the value for thicknesses greater than 40 mm.
- For welded plate I or H sections where it can be guaranteed that the edges of the flanges will only be flame-cut, $a = 3,5$ may be used for buckling about the y-y axis for flanges up to 40 mm thick and, $a = 5,5$ for flanges over 40 mm thick.
- Yield strength for sections fabricated from plate by welding reduced by 25 N/mm².
- 'Welded box sections' include those fabricated from four plates, two angles or an I or H section and two plates but not box sections composed of two channels or plates with welded longitudinal stiffeners.

Table 5.4.4 Value K , for different constraint conditions

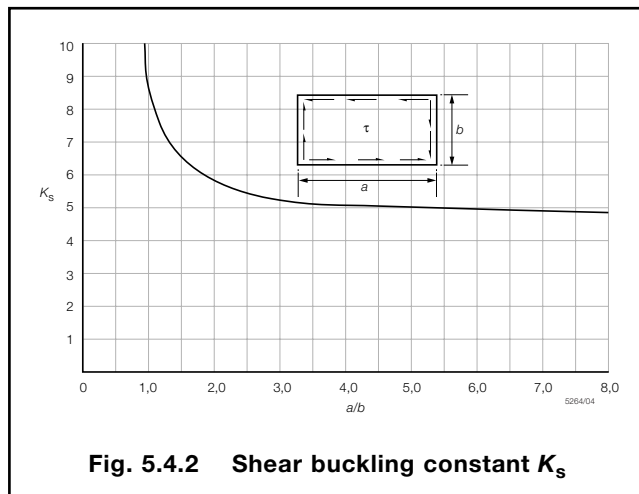
Diagrammatic representation	Restraint conditions	K
	Constrained against rotation and translation at both ends	0,7
	Constrained against rotation and translation at one end and translation only at other end	0,85
	Constrained against translation only at each end	1,0
	Constrained against rotation and translation at one end and against rotation only at other end	1,5
	Constrained against rotation and translation at one end and free to rotate and translate at other end	2,0



Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Section 4



$$(d) \left(\frac{\tau}{\tau_b} \right)^2 + \left(\frac{\sigma_c}{\sigma_{cb}} \right) + \left(\frac{\sigma_b}{\sigma_{bb}} \right)^2 < F$$

4.4 Allowable stress – Joints and connections

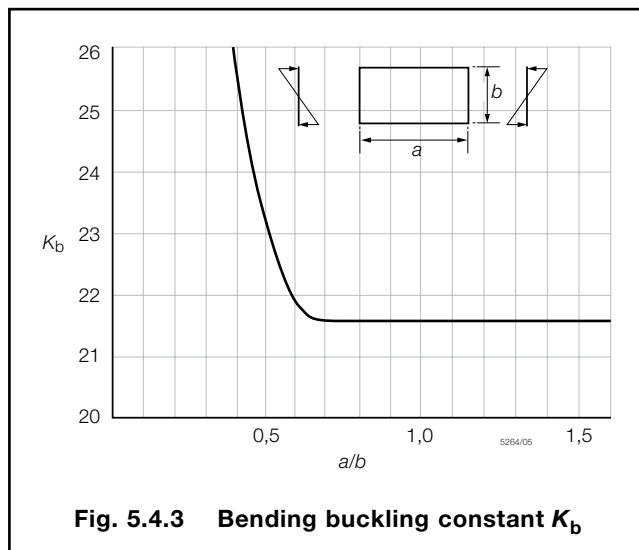
4.4.1 For welded joints, the physical properties of the weld metal are considered as equal to the parent metal. For full penetration butt welds subjected to direct and shear stresses the allowable stress is equal to the allowable tensile stress of the parent material.

4.4.2 For fillet welds and welds subjected to shear, the allowable stresses are reduced. Values of these reduced stresses are given in Table 5.4.5. Where, F , is the stress factor, see Table 5.4.1.

Table 5.4.5 Allowable stresses in welds, N/mm²

Type of weld	Allowable stress	
	Direct	Shear
Full penetration butt weld	$1,0 F\sigma_y$	$0,58 F\sigma_y$
Fillet welds	$0,7 F\sigma_y$	$0,58 F\sigma_y$

4.4.3 The design stress in fillet welds is to be calculated on the 'throat' dimension of the weld, see Fig. 5.4.4.



4.3.6 For components subject to combined bending and shear, the following stress criteria are to be met:

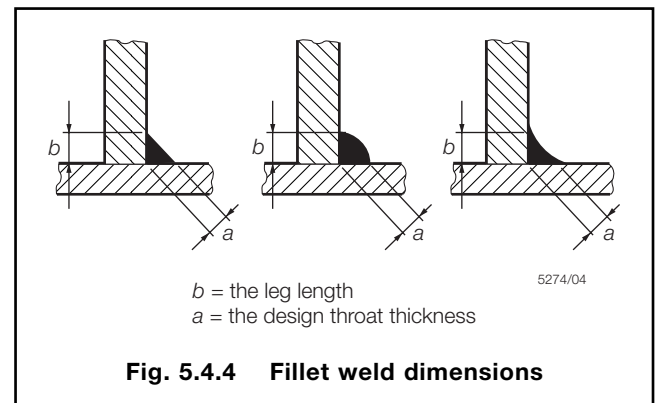
- (a) $\sigma_b < F\sigma_{bb}$
- (b) $\tau < F\tau_b$
- (c) $\frac{\sigma_b}{\sigma_b} + \left(\frac{\tau}{\tau_b} \right)^2 < F$

4.3.7 For components subject to combined bending and compression the following allowable stress criteria are to be met:

- (a) $\sigma_c < F\sigma_{cb}$
- (b) $\sigma_b < F\sigma_{bb}$
- (c) $\frac{\sigma_c}{\sigma_{cb}} + \left(\frac{\sigma_b}{\sigma_{bb}} \right)^2 < F$

4.3.8 For components subject to combined compression, bending and shear, the following allowable stress criteria are to be met:

- (a) $\sigma_c < F\sigma_{cb}$
- (b) $\sigma_b < F\sigma_{bb}$
- (c) $\tau < F\tau_b$



4.4.4 The strength of joints using pretensioned bolts to transmit shear and/or tensile forces, e.g. high strength friction grip bolts, is to be determined in accordance with an appropriate National or other acceptable code or standard.

4.4.5 For joints using precision bolts, defined as turned or cold finished bolts fitted into drilled or reamed holes whose diameter is not greater than the bolt diameter by more than 0,4 mm, the allowable stress due to the externally applied load is given in Table 5.4.6.

Bridge/Vehicle Ramp Strength

Part 3, Chapter 5

Section 4

Table 5.4.6 Allowable stresses for fitted bolts

Type of loading	Allowable stress	
	Load cases 1 and 3	Load case 2
Tension	$0,4 \sigma_y$	$0,54 \sigma_y$
Single shear	$0,38 \sigma_y$	$0,51 \sigma_y$
Double shear	$0,57 \sigma_y$	$0,77 \sigma_y$
Tension and shear	$0,48 \sigma_y$	$0,64 \sigma_y$
$(\sigma_t^2 + 3\tau^2)^{\frac{1}{2}}$		
Bearing	$0,9 \sigma_y$	$1,2 \sigma_y$

4.4.6 Where joints are subjected to fluctuating or reversal of load across the joint the bolts are to be pretensioned by controlled means to between 70 and 80 per cent of their specified yield stress.

4.4.7 Black bolts (ordinary grade bolts) are not to be used for primary joints or joints subject to fatigue.

4.5 Deck plating thickness

4.5.1 The deck plating thickness, t , for bridges and ramps is to be adequate for the intended vehicle traffic and is to be calculated with reference to the method described in Ch 4.3.3.

4.5.2 In addition to accommodating the local tyre print loads, the deck plating may also contribute to the overall strength of the bridge or ramp and therefore is to satisfy the allowable stress criteria of 4.1 and the plate buckling requirements in 4.3.

4.6 Deflection criteria

4.6.1 In Case 1 the deflection of the bridge or ramp between supports under the applied load is to be limited to that given by the following expression:

$$\frac{L}{400} \text{ mm}$$

where

L = distance between supports, in mm.

4.6.2 For cantilevered sections of bridges and ramps the

deflection is to be limited to $\frac{L}{200}$ mm

where

L is the length of the cantilevered section.

4.7 Hoisting and slewing arrangements

4.7.1 Where chains are used as part of the hoisting or slewing arrangement they are to have a minimum safety factor of 4,0.

4.7.2 Where wire ropes are used as part of the hoisting or slewing arrangement the safety factor is to be determined as:

$$SF = \frac{10^4}{8,85W + 1910}$$

where

SF = minimum safety factor required

W = weight of the ramp in tonnes (for ramps which are unloaded during manoeuvring)

The actual design safety factor is to be not less than four and need not be greater than five.

4.8 Locking arrangements

4.8.1 Where bridges and ramps are raised or lowered in the unloaded condition and then pinned or locked off to support both the dead weight and vehicle loads, the pins (or locking device) are to be adequate for the worst loading derived from Case 1 and are to satisfy the allowable stress criteria of 4.1 to 4.4.

4.9 Safety restraints

4.9.1 Where a bridge or ramp is retained in position by a single articulated mechanical connection a suitable means is to be provided to prevent the complete detachment of the bridge or ramp from the support in the event of failure of the joint.

4.9.2 Chains or wire ropes used for this purpose are to take due account of the kinetic energy developed by the falling structure and are to have a safety factor of at least two.

4.9.3 To prevent movement and consequent failure, pins for all primary hinges and articulations are to be locked in position by adequate keep plates, castellated and wired nuts, end cover plates or other suitable means.

4.10 Deck gradients and transitions

4.10.1 The gradients of bridges and ramps are in general not to exceed a slope of 1 in 10 during normal operation with ships at lowest or highest freeboard at Mean Low or High Water Spring Tides respectively. Additionally, a maximum slope of 1 in 8 will be permitted for Lowest and Highest Astronomical Tides.

4.10.2 Changes in bridge or ramp gradients and transitions are to take account of ground clearance of the vehicles using the linkspan throughout the operational range.

Passenger Walkway Strength

Part 3, Chapter 6

Sections 1, 2 & 3

Section

- 1 **General**
- 2 **Materials**
- 3 **Design loads and combinations**
- 4 **Design criteria**

■ Section 1 General

1.1 Application

1.1.1 This Chapter provides the design requirements for walkways and their support structures.

1.1.2 This Chapter is not applicable to ships' gangways, accommodation ladders, pilot ladders, or service/maintenance platforms, etc., on linkspans.

1.1.3 Walkways providing access as part of a linkspan may be an independent structure or may be integrated into the linkspan bridge or vehicle ramp. Suitable segregation of vehicular from other traffic is to be provided.

1.2 Objective

1.2.1 The scantlings and supporting arrangements are to be consistent with the method of support, the environmental conditions prevailing at the operating location, the berthing conditions and the specified pedestrian loading data.

1.2.2 Additionally, consideration is to be given, as appropriate, to the proposed frequency of use.

1.3 Information required for approval

1.3.1 See Ch 1,8.

■ Section 2 Materials

2.1 General requirements

2.1.1 The materials used in the construction of walkways, including their support arrangements and any articulations, are to comply with the requirements of the *Rules for the Manufacture, Testing and Certification of Materials*, as appropriate.

■ Section 3 Design loads and combinations

3.1 General

3.1.1 When loaded, walkways are to be considered for the worst possible combination of inclinations and support arrangements arising from the following forces:

- (a) Self-weight.
- (b) Specified loading.
- (c) Static and dynamic forces due to inclination and movement of the pontoon or other buoyant support.
- (d) Operational environmental loads.
- (e) Loads due to ship movement transmitted to the walkway through any ship to linkspan connection.

3.1.2 When unloaded and out-of-service, walkways are to be considered for the worst possible combination of slope, twist angles and support arrangements arising from the following forces acting on the whole linkspan:

- (a) Self-weight.
- (b) Static and dynamic forces due to inclination and movement of the pontoon or other buoyant support.
- (c) Extreme environmental loads appropriate to the location (e.g. wind, wave or current).

3.2 Basic load factors

3.2.1 The self-weight load, L_w , is to be taken as the weight of the walkway for all design conditions except when it is being mechanically raised or lowered in which case it is to be multiplied by a factor of 1,1.

3.2.2 The applied load, L_c , is the load on the walkway from passengers. This is usually expressed as a UDL and need not be increased by a dynamic factor as sufficient allowance has been incorporated for the effects of pedestrian movement, unless otherwise stated.

3.2.3 Environmental loads, L_e , need not be increased by any factor.

3.3 Forces due to motion of the pontoon or other buoyant support

3.3.1 Walkways are to be designed to operate safely and efficiently when accommodating any inclination or dynamic movement of the pontoon or other buoyant structure from which they derive their support.

Passenger Walkway Strength

Part 3, Chapter 6

Sections 3 & 4

3.4 Load combinations

3.4.1 Walkways are to be considered for the design loadings resulting from the following load cases:

- (a) Case 1: Loaded operational - in service condition.
- (b) Case 2: Unloaded, out of service, survival condition.
- (c) Case 3: Manoeuvring condition when unloaded (if appropriate), i.e. when being mechanically hoisted or lowered.

Case 1: The walkway is to be considered with respect to self-weight plus applied load, together with any horizontal, vertical and rotational forces resulting from pontoon movement and slope of the walkway, together with any loads imposed by the ship and any environmental loading. This is represented by the following expression:

$$L_w + L_c + L_{vp} + L_{Hp} + L_{rp} + L_{\theta} + L_e + L_{sr} + L_s$$

where the above loads are added vectorially, and where

- L_w = self-weight load
- L_c = applied load
- L_{vp} = vertical force from pontoon movement
- L_{Hp} = horizontal force from pontoon movement
- L_{rp} = rotational force from pontoon movement
- L_{θ} = load due to slope of bridge/ramp
- L_e = environmental forces (wind and snow and ice as appropriate)
- L_{sr} = load from ship's ramp
- L_s = loads due to ship movement transmitted through any ship to linkspan connection.

Case 2: The walkway is to be considered with respect to the direct forces resulting from the extreme environmental conditions (generally 1 in 50 year return case) and from the corresponding forces acting on the self-weight resulting from the accelerations due to pontoon motions and static inclination resulting from the same severe environmental conditions.

Case 3: The walkway is to be considered with respect to its self-weight multiplied by 1,1, together with any additional horizontal forces resulting from pontoon motions (see 3.3.1), and environmental forces. This is represented by the following expression:

$$1,1L_w + L_{vp} + L_{Hp} + L_e$$

where the above loads are added vectorially.

4.3 Hoisting and slewing arrangements

4.3.1 The safety factors for chains and steel wire ropes used for hoisting or slewing operations are as defined in Ch 5,4.7.

4.4 Safety restraints

4.4.1 Where a bridge or ramp is retained in position by a single articulated mechanical connection, a suitable means is to be provided to prevent the complete detachment of the bridge or ramp from the support in the event of failure of the joint.

4.4.2 Chains or wire ropes used for this purpose are to take due account of the kinetic energy developed by the falling structure and are to have a safety factor of at least 2,0.

4.4.3 To prevent movement and consequent failure, pins for all primary hinges and articulations are to be locked in position by adequate keep plates, castellated and wired nuts, and cover plates or other suitable means.

■ Section 4 Design criteria

4.1 Allowable stresses

4.1.1 The allowable stress criteria to be used for walkways are as defined in Ch 5,4.1 to 4.4 inclusive.

4.2 Deflection criteria

4.2.1 The allowable deflection criteria for walkways are as defined in Ch 5,4.6.

Mooring and Tethering Arrangements

Part 3, Chapter 7

Sections 1, 2 & 3

Section

1 General

2 Materials

3 Types of mooring and tethering arrangements

4 Design loads

5 Load combinations

6 Safety factors and allowable stresses

Section 1 General

1.1 Application

1.1.1 This Chapter is applicable to all linkspans that are either totally or partially supported by buoyant means.

1.1.2 This Chapter does not apply to linkspans that are supported by a bankseat bearing at one end and by a non-buoyant structure at the other end.

1.2 Scope

1.2.1 This Chapter is applicable to those aspects of mooring systems and tethering arrangements sufficient to assign the **T** class character symbol, see Pt 1, Ch 2,3.2, to be assigned, viz:

- (a) Mooring lines, chains, their shackles and links.
- (b) Yokes and guides around piles.
- (c) Permanent attachments to pontoons, bridge and ramp pontoons.
- (d) Mooring booms.

1.2.2 The design and construction of the following is not covered by these Rules:

- (a) Guidepiles and dolphins.
- (b) Sea-bed conditions supporting guidepiles, dolphins and catenary chain anchor blocks.
- (c) Quay mounted bollards.
- (d) Civil engineering structures, including quays, bankseats, etc.

1.3 Objective

1.3.1 Each buoyant linkspan is to be secured on station by a mooring system or tethering arrangement that is able to adequately and efficiently resist environmental, operational and berthing forces applied to the linkspan.

1.3.2 The mooring system or tethering arrangement adopted is also to accommodate the full tidal range possible at the location without restricting the vertical movement of the linkspan due to the rise and fall of the tide.

Section 2 Materials

2.1 Approved manufacturers

2.1.1 All chains, ropes, cables and loose gear used for mooring systems are to be supplied from an approved manufacturer and are to have been tested in a Recognized Proving Establishment as defined in LR's *List of Approved Manufacturers and Recognized Proving Establishments*.

2.2 Tethering arrangements

2.2.1 The material used in any fabricated primary structural member in the tethering arrangement is to comply with the *Rules for the Manufacture, Testing and Certification of Materials*.

Section 3 Types of mooring and tethering arrangements

3.1 Mooring arrangements

3.1.1 Mooring systems generally consist of one of the following arrangements:

- (a) Mooring lines and chains retaining the linkspan against a quayside or series of dolphins.
- (b) A system of mooring booms keeping the linkspan at a fixed distance from the quayside.

3.2 Tethering arrangements

3.2.1 Tethering arrangements will generally consist of:

- (a) Two or more guidepiles attached to the linkspan by a yoke (or yokes) permitting vertical movement of the linkspan but restraining horizontal movement.
- (b) A single guidepile and yoke at one end of the linkspan allowing vertical tidal movement, and a bankseat arrangement allowing rotation but providing suitable translational restraint.

3.3 Other types

3.3.1 Other types of mooring or tethering arrangements will be considered.

Mooring and Tethering Arrangements

Part 3, Chapter 7

Sections 3, 4, 5 & 6

3.3.2 Where the means of securing the installation is provided by frictional support from the sea bed, the pontoons are to have a factor of safety of at least 2,0 against sliding or bearing capacity failures under all loading conditions occurring at the operating location.

The available unit friction between pontoon and soil (or along any other potential failure surface, for example, between a fabric drainage mat and soil) may be required to be verified by tests. Attention is to be paid to the need to ensure good and complete contact between pontoon and soil, and to guard against possible scour from current and underbase erosion due to sub-surface erosion caused by water pressure under the base. In general, this type of securing is to be considered only for well protected locations, but each submission will be considered with respect to calculations and test data supplied by the designer.

Section 4 Design loads

4.1 Environmental loads

4.1.1 Each mooring system or tethering arrangement is to be considered with respect to the following environmental loads:

- (a) Wind loading, see Ch 3,3.6.
- (b) Current loading, see Ch 3,3.7.
- (c) Wave loading, see Ch 3,3.8.

4.2 Operational loads

4.2.1 Each system is to be considered with respect to the following operational loads:

- (a) Vehicle movement including braking, see Ch 3,3.4.3.
- (b) Vehicle accident or skidding, see Ch 3,3.4.3.
- (c) Forces arising from the extension/retraction of a pontoon relative to the linkspan bridge/ramp.
- (d) Forces transmitted through any linkspan to ship connection.
- (e) Wash from passing marine craft.

4.3 Berthing loads

4.3.1 Each system is to be considered with respect to ship berthing loads as defined in Ch 3,3.9.

4.3.2 Where appropriate, consideration is to be given to the effects of the berthing ship's propulsion units.

Section 5 Load combinations

5.1 General

5.1.1 Each mooring system and tethering arrangement is to be considered for the following design cases:

- (a) Case 1 – In-service operational.
- (b) Case 2 – In-service berthing.
- (c) Case 3 – Out of service – severe environmental conditions.

5.1.2 **Case 1.** Each system is to be adequate for the worst combination of normal operational wind, current and wave loadings, together with one of the operational loads in 4.2. This can be represented by the following expression:

$$L_{\text{wind}.1} + L_{\text{current}.1} + L_{\text{wave}.1} + L_{\text{operational}}$$

where the above loads are added vectorially.

5.1.3 **Case 2.** Each mooring system and tethering arrangement is to be adequate for the worst combination of normal operational wind, current and wave loadings, together with the normal berthing force including the effects of the ship's propulsion units, where appropriate. This can be represented by the following expression:

$$L_{\text{wind}.1} + L_{\text{current}.1} + L_{\text{wave}.1} + L_{\text{berthing}}$$

where the above loads are added vectorially.

5.1.4 **Case 3.** Each mooring system and tethering arrangement is to be adequate for the worst combination of extreme wind, current and wave loadings together with any wash effects from passing ships, where appropriate. It is assumed that in this condition the linkspan will be out of service and no ship will be berthed or berthing. This is represented by:

$$L_{\text{wind}.2} + L_{\text{current}.2} + L_{\text{wave}.2}$$

where the above loads are added vectorially.

Section 6 Safety factors and allowable stresses

6.1 Safety factors

6.1.1 The various components of mooring systems are to have, as a minimum, the safety factors given in Table 7.6.1.

6.1.2 These safety factors assume adequate regular inspection and/or renewal. Higher safety factors may need to be considered if:

- (a) the linkspan is outside protected waters (see Pt 1, Ch 2,1.2.3); or
- (b) the in-service operational wind, wave and current loadings are likely to be frequently exceeded; or
- (c) regular and adequate inspection and maintenance procedures may not be followed.

Mooring and Tethering Arrangements

Part 3, Chapter 7

Section 6

Table 7.6.1 Safety factors

Component	Safety factor for normal operating conditions	Safety factor for extreme conditions
Chain	3:0	2:0
Ropes (SWR & synthetic)	3:0	2:0
Shackles and links	Max. load = SWL	Max. load < Proof Load

6.2 Allowable stresses

6.2.1 The allowable stress criteria defined in Ch 5,4 will be appropriate for any fabricated components forming part of a tethering arrangement.

6.2.2 The stress factors to be used in calculating the allowable stresses for load cases 1, 2 and 3 are given in Table 7.6.2.

Table 7.6.2

Load case	1	2	3
Stress Factor, F	0,6	0,6	0,75

Fendering Systems

Part 3, Chapter 8

Sections 1 & 2

*Section***1 General****2 Design**

2.1.4 Where fenders are located between the bankseat and the shore end of the linkspan, suitable rubbing strips or other means of protection are to be provided at the ship-to-linkspan contact zone.

■ Section 1 General

1.1 Application

1.1.1 Where it is intended, as part of normal operational procedures, for the berthing ship to make contact with a linkspan, a fendering system is to be fitted capable of absorbing the forces from ships berthing end-on or near end-on to, or alongside, the linkspan.

1.1.2 Fendering systems are to be considered for both the normal and abnormal berthing conditions defined in Ch 3,3.9.

1.1.3 The supporting structure or mountings for fenders are to be capable of withstanding the fender reaction forces specified in the manufacturer's performance characteristics for each fender.

1.1.4 Fenders are generally proprietary items and as such do not require to be made under survey or tested. Nevertheless, they should be supplied with appropriate certificates verifying their construction and capacity to the satisfaction of the attending Surveyor.

1.1.5 All fender units are to be installed under survey in accordance with the manufacturer's recommendations.

1.1.6 Where it is not intended, as part of normal operational procedures, for berthing ships to contact the linkspan, a statement to this effect is to be made to LR. In such circumstances a fendering system need not be fitted. However, it is recommended that this situation is made clear to all operators using the installation.

■ Section 2 Design

2.1 General

2.1.1 Fenders may be elastomeric, pneumatic, foam filled, or of other suitable form.

2.1.2 For limiting deflections under abnormal impact conditions, reference is to be made to the manufacturer's published performance characteristics.

2.1.3 Special consideration will be given to fenders manufactured for a specific installation.

Appendix for Highway Loads, Section Aerodynamics and Pontoon Drag Coefficients

Part 3, Chapter 9

Section 1

Section

1 **Alternative highway live loads based on BS 5400 Part 2 1978 – HA and HB**

2 **Aerodynamic data**

3 **Drag coefficients for pontoons**

■ Section 1 Alternative highway live loads based on BS 5400 Part 2 1978 – HA and HB (see Ch 3,3.4.5)

1.1 General

1.1.1 Standard highway loading consists of HA and HB loading.

1.1.2 HA loading is a formula loading representing normal traffic in the UK:

- HB loading is an abnormal vehicle unit loading.
- Both loadings include an allowance for impact.

1.2 Type HA loading

1.2.1 Type HA loading consists of a uniformly distributed load and a knife edge load combined, or of a single wheel load.

1.2.2 **Nominal uniformly distributed load (UDL).** For loaded lengths up to 50 m, the UDL shall be derived from the equation:

$$\text{UDL} = 336 \left(\frac{1}{L} \right)^{0,67} \text{ kN/m}$$

where

L is the loaded length, in metres

For lengths in excess of 50 m, the UDL shall be derived from the equation

$$\text{UDL} = 36 \left(\frac{1}{L} \right)^{0,1} \text{ kN/m}$$

but not less than 21,8 kN/m

Values for this load per linear metre of notional lane are given in Table 9.1.1.

1.2.3 **Nominal knife edge load (KEL).** The KEL per notional lane shall be taken as 120 kN.

1.2.4 **Distribution.** The UDL and KEL shall be taken to occupy one notional lane, uniformly distributed over the full width of the lane.

1.2.5 **Dispersal.** No allowance for the dispersal of the UDL and KEL shall be made.

Table 9.1.1 Type HA uniformly distributed load

Loaded length m	Load, UDL kN/m	Loaded length m	Load, UDL kN/m
2	211,2	44	26,6
4	132,7	47	25,5
6	101,2	50	24,4
8	83,4	55	24,1
10	71,8	60	23,9
12	63,6	65	23,7
14	57,3	70	23,5
16	52,4	75	23,4
18	48,5	80	23,2
20	45,1	85	23,1
23	41,1	90	23,0
26	37,9	100	22,7
29	35,2	110	22,5
32	33,0	120	22,3
35	31,0	130	22,1
38	29,4	150	21,8
41	27,9		

1.2.6 **Single nominal wheel load alternative to UDL and KEL.** One 100 kN wheel, placed on the carriageway and uniformly distributed over a circular contact area assuming an effective pressure of 1,1 N/mm² (i.e. 340 mm diameter), shall be considered.

Alternatively, a square contact area may be assumed, using the same effective pressure (i.e. 300 mm side).

1.2.7 **Dispersal.** Dispersal of the single nominal wheel load at a spread-to-depth ratio of one horizontally to two vertically through asphalt and similar surfacing may be assumed, where it is considered that this may take place.

Dispersal through structural concrete slabs may be taken at a spread-to-depth ratio of one horizontally to one vertically down to the neutral axis.

1.3 Type HB Loading

1.3.1 For all public highway bridges in Great Britain, the minimum number of units of type HB loading that shall normally be considered is 30, but this number may be increased up to 45 if so directed by the appropriate authority.

For the purposes of these Rules these figures may also apply to the bridges and ramps on a linkspan.

1.3.2 **Nominal HB loading.** Fig. 9.1.1 shows the plan and axle arrangement for one unit of nominal HB loading. One unit shall be taken as equal to 10 kN per axle (i.e. 2,5 kN per wheel).

The overall length of the HB vehicle shall be taken as 10, 15, 20, 25 or 30 m for inner axle spacings of 6, 11, 16, 21 or 26 m respectively, and the effects of the most severe of these cases shall be adopted.

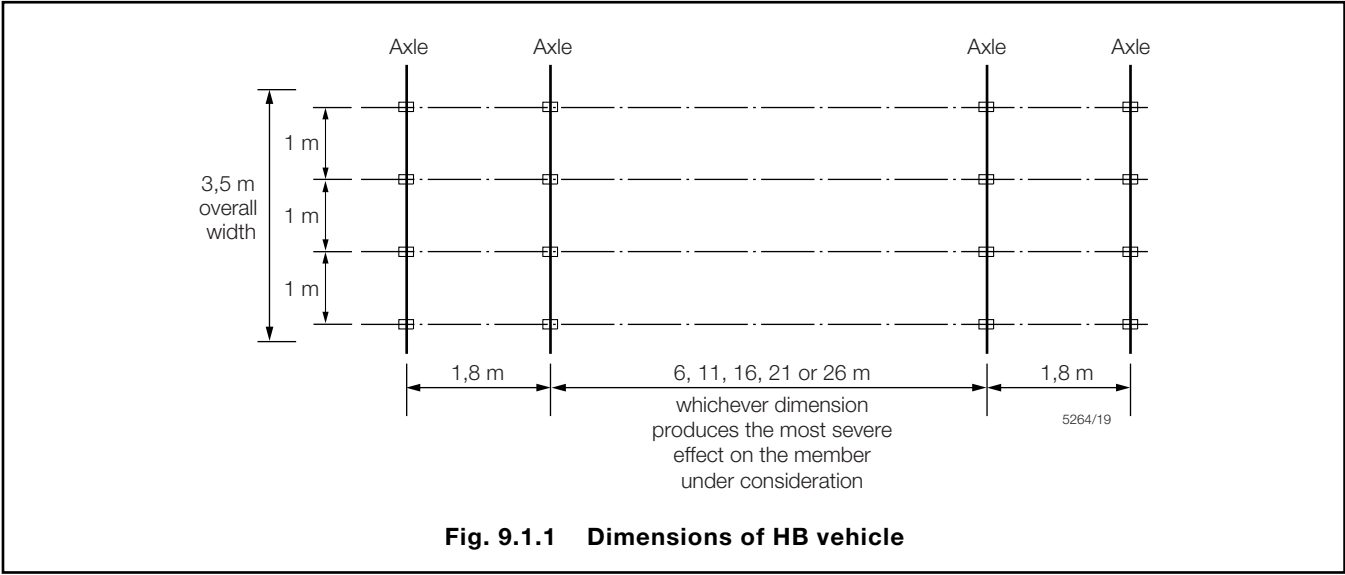
The overall width shall be taken as 3,5 m.

1.3.3 **Contact area.** Nominal HB wheel loads shall be assumed to be uniformly distributed over a circular contact area, assuming an effective pressure of 1,1 N/mm².

Alternatively, a square contact area may be assumed, using the same effective pressure.

Appendix for Highway Loads, Section
Aerodynamics and Pontoon Drag Coefficients

Part 3, Chapter 9
Sections 1 & 2

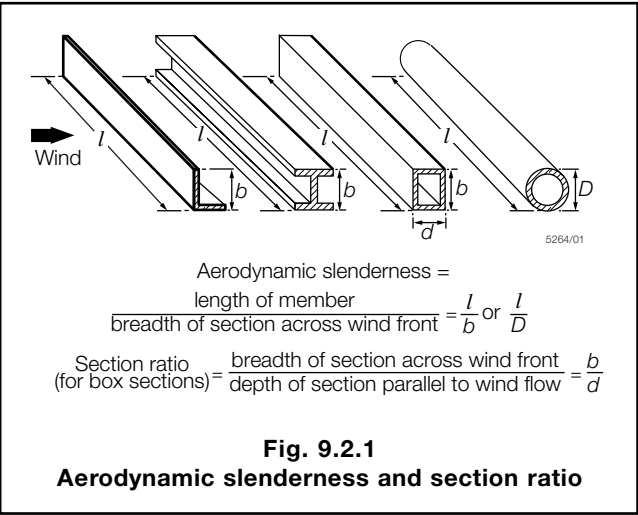


1.3.4 **Dispersal.** Dispersal of HB wheel loads at a spread-to-depth ratio of one horizontally to two vertically through asphalt and similar surfacing may be assumed, where it is considered that this may take place.

Dispersal through structural concrete slabs may be taken at a spread-to-depth ratio of one horizontally to one vertically down to the neutral axis.

1.4 **Derivation and application of HA and HB loading**

1.4.1 For further details on the derivation of HA and HB loadings and for further information regarding their application to highways, reference is to be made to BS 5400: Part 2, 1978.



■ **Section 2
Aerodynamic data**

2.1 **Wind force coefficient, C_f**

2.1.1 The force coefficient for various structural components is given in Table 9.2.1. The values for individual members vary according to the aerodynamic slenderness and in the case of large box sections, with the section ratio.

2.2 **Aerodynamic slenderness and section ratio**

2.2.1 The aerodynamic slenderness and section ratio are defined in Fig. 9.2.1.

2.3 **Shielding and solidity factors**

2.3.1 Where a structure consists of a framework of members such that shielding takes place, the wind force on the windward frame or member and on the sheltered parts of those behind it is calculated using the appropriate force coefficient. The force coefficient on the sheltered parts is to be multiplied by a shielding factor η . The values of η vary with the solidity and spacing ratio of the framework. Values of η are given in Table 9.2.2 for the solidity and spacing ratio as defined in Fig. 9.2.2.

Appendix for Highway Loads, Section Aerodynamics and Pontoon Drag Coefficients

Part 3, Chapter 9

Section 2

Table 9.2.1 Force coefficient (C_f)

Type	Description	Aerodynamic slenderness l/b or l/D					
		5	10	20	30	40	50
		Force coefficient C_f					
Individual members	Rolled sections, rectangles, hollow sections, flat plates, box section with b or d less than 0,5 m	1,30	1,35	1,60	1,65	1,70	1,80
	Circular section, where $DV_s < 6,0 \text{ m}^2/\text{s}$ $DV_s \geq 6,0 \text{ m}^2/\text{s}$	0,75	0,80	0,90	0,95	1,00	1,10
		0,60	0,65	0,70	0,70	0,75	0,80
	Box sections with b or d greater than 0,5 m	$b/d \geq 2,00$	1,55	1,75	1,95	2,10	2,20
		1,00	1,40	1,55	1,75	1,85	1,90
		0,50	1,00	1,20	1,30	1,35	1,40
0,25		0,80	0,90	0,90	1,00	1,00	
Single lattice frames	Flat sided sections	1,70					
	Circular section, where $DV_s < 6,0 \text{ m}^2/\text{s}$ $DV_s \geq 6,0 \text{ m}^2/\text{s}$	1,20 0,80					
Machinery houses, etc.	Rectangular clad structures on ground or solid base (air flow beneath structure prevented)	1,10					
NOTES							
D = the diameter of the section, in metres							
V_s = the design wind speed, in m/s							

Table 9.2.2 Shielding factor (η)

Spacing ratio a/b	Solidity ratio A/A_e					
	0,1	0,2	0,3	0,4	0,5	0,6
0,5	0,75	0,4	0,32	0,21	0,15	0,1
1,0	0,92	0,75	0,59	0,43	0,25	0,1
2,0	0,95	0,8	0,63	0,5	0,33	0,2
4,0	1	0,88	0,75	0,66	0,55	0,45
5,0	1	0,95	0,88	0,81	0,75	0,68
6,0	1	1	1	1	1	1

2.3.2 Where a structure consists of a number of identical frames or members spaced equidistantly behind each other in such a way that each frame shields those behind it, the wind load is to be obtained from the following expression:

$$F = A P C_f \left(\frac{1 - \eta^n}{1 - \eta} \right)$$

where

η = shielding factor from Table 9.2.2 but to be taken as not less than 0,1

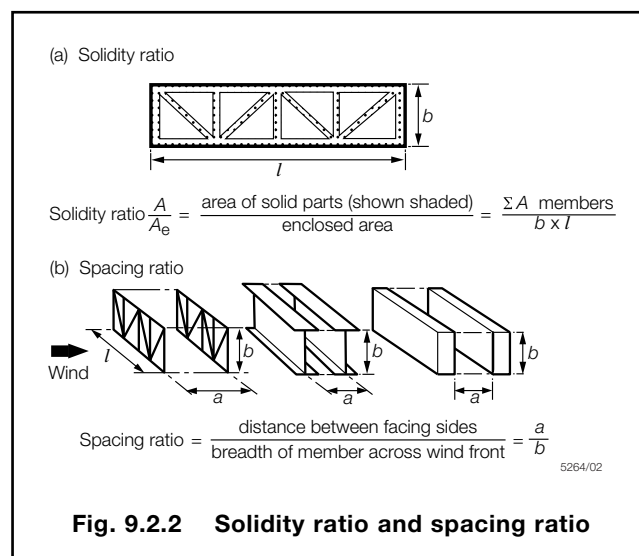
n = number of frames, but to be taken as not greater than nine

C_f = force coefficient from Table 9.2.1

and A and P are as defined in Ch 3,3.6.3.

2.4 Tower sections

2.4.1 For latticed tower structures, the 'face on' wind force based on the solid area of the windward face is to be calculated using the following factored pressures:



(a) For towers composed of flat-sided sections:
 $1,7P (1 + \eta)$

(b) For towers composed of circular sections:
where
 $DV_s < 6,0 \text{ m}^2/\text{s} : 1,2P (1 + \eta)$
and
 $DV_s \geq 6,0 \text{ m}^2/\text{s} : 1,4P (1 + \eta)$

where

D and V_s are defined in Table 9.2.1.

The value of η is taken from Table 9.2.2 for $a/b = 1,0$ according to the solidity ratio of the windward face.

2.4.2 The maximum wind load on a square section tower occurs when the wind blows on to a corner and is to be taken as 1,2 times the 'face on' load.

Appendix for Highway Loads, Section Aerodynamics and Pontoon Drag Coefficients

Part 3, Chapter 9

Section 3

Section 3

Drag coefficients for pontoons

3.1 General

3.1.1 The nature of the forces on floating bodies is considerably complex and not fully understood. In theory, the forces depend on factors such as speed of flow, area normal to the flow, total wetted area, roughness, detailed form or shape, and the proximity of the seabed or other boundaries and bodies. In practice, simplifications are made when describing forces.

3.2 Wall-sided boxes

3.2.1 Towing tests on wall-sided boxes have also been performed and results are reproduced in Table 9.3.1.

Table 9.3.1 Typical current drag coefficients for wall-sided boxes

Shape of model	Breadth/draught ratio B/D	Drag force coefficient C_D
Square	8,1	0,72
	3,4	0,70
	1,6	0,86
NOTE A drag coefficient of 1,0 should be used unless more reliable values can be obtained.		

3.3 Pontoons and barges

3.3.1 There are very little data on forces or coefficients for floating structures such as barges and pontoons. However, towing tests on barges have been performed, and graphs of typical drag coefficients are reproduced in Figs. 9.3.1 to 9.3.4.

3.3.2 The coefficients in Figs. 9.3.1 and 9.3.2 and Table 9.3.1 apply when the water is deep (depth/draught ≥ 5). The coefficients in Fig. 9.3.3 and Fig. 9.3.4 apply in shallow water.

The following equations should be used when applying the coefficients given in Figs. 9.3.1 to 9.3.4.

$$F_x = \frac{1}{2} (C_x \rho V^2 A_x)$$

$$F_y = \frac{1}{2} (C_y \rho V^2 A_y)$$

where

F_x = the current force along the longitudinal (x) axis (in kN)

F_y = the current force along the transverse (y) axis (in kN)

C_x = the longitudinal current force drag coefficient

C_y = the transverse current force drag coefficient

ρ = the mass density of water (in t/m³)

A_x = the effective current area normal to the longitudinal (x) axis (in m)

A_y = the effective current area normal to the transverse (y) axis (in m)

V = the incident current velocity (in m/s).

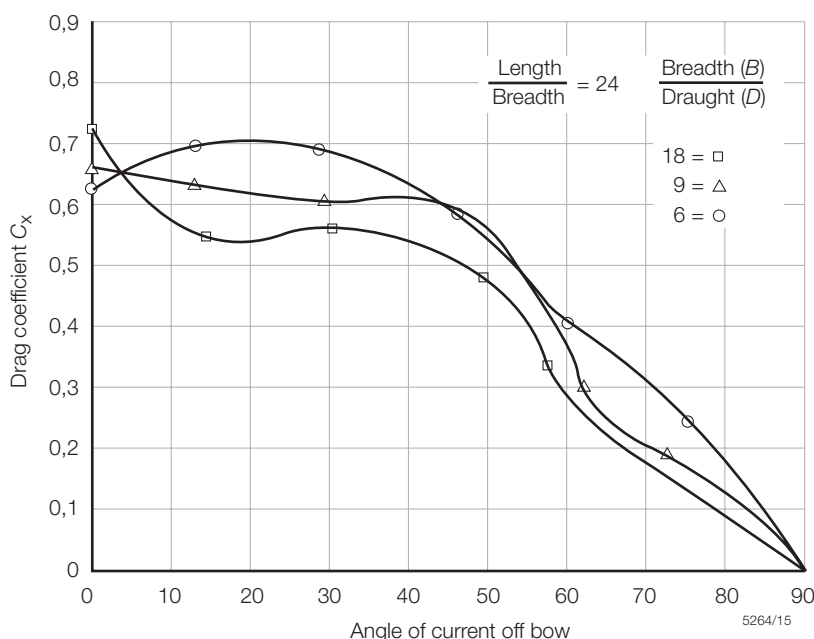


Fig. 9.3.1 Longitudinal drag coefficient for rectangular pontoon in deep water

Appendix for Highway Loads, Section Aerodynamics and Pontoon Drag Coefficients

Part 3, Chapter 9

Section 3

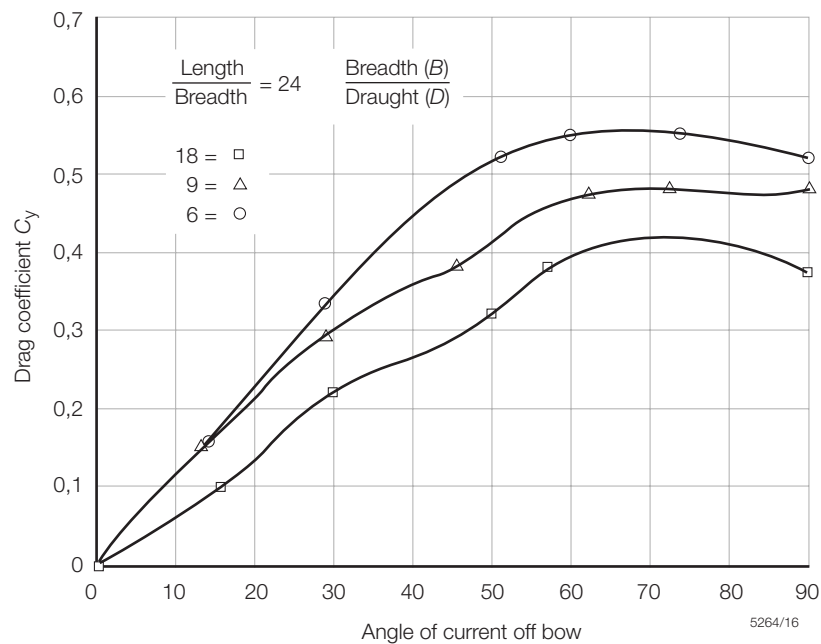


Fig. 9.3.2 Transverse drag coefficient for rectangular pontoon in deep water

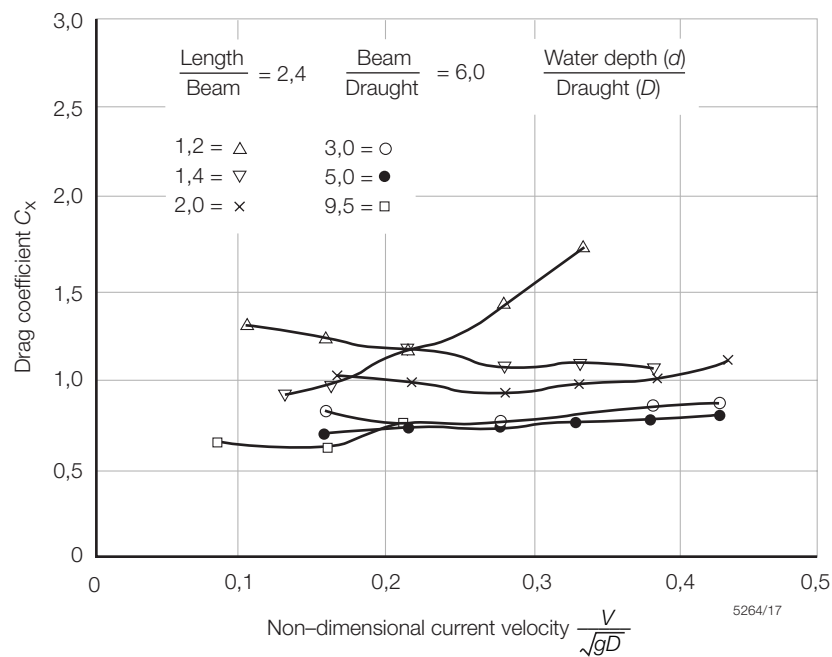


Fig. 9.3.3
Longitudinal drag coefficient at various water depths for rectangular pontoon with current head on

Appendix for Highway Loads, Section
Aerodynamics and Pontoon Drag Coefficients

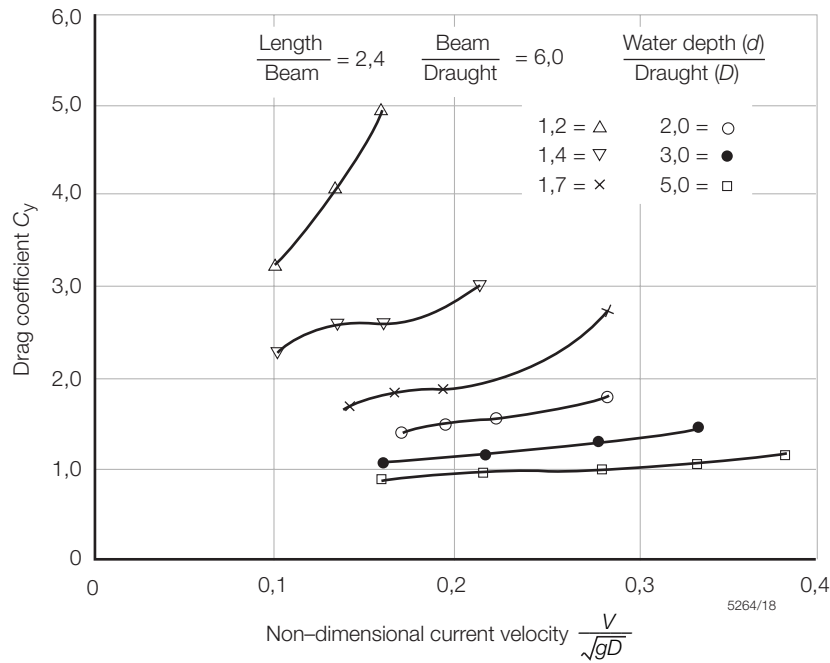


Fig. 9.3.4
Transverse drag coefficient at various water depths for rectangular pontoon with current beam on

© Lloyd's Register, 2008
Published by Lloyd's Register
Registered office
71 Fenchurch Street, London, EC3M 4BS
United Kingdom

RULES AND REGULATIONS FOR THE CLASSIFICATION OF LINKSPANS

ENGINEERING SYSTEMS

JULY 2008

PART 4

Lloyd's
Register

A guide to the Rules

and published requirements

Rules and Regulations for the Classification of Linkspans

Introduction

The Rules are published as a complete set, individual Parts are, however, available on request. A comprehensive List of Contents is placed at the beginning of each Part.

Numbering and Cross-References

A decimal notation system has been adopted throughout. Five sets of digits cover the divisions, i.e. Part, Chapter, Section, sub-Section and paragraph. The textual cross-referencing within the text is as follows, although the right hand digits may be added or omitted depending on the degree of precision required:

- (a) In same Chapter, e.g. see 2.1.3 (i.e. down to paragraph).
- (b) In same Part but different Chapter, e.g. see Ch 3,2.1 (i.e. down to sub-Section).
- (c) In another Part, e.g. see Pt 2, Ch 1,3 (i.e. down to Section).

The cross-referencing for Figures and Tables is as follows:

- (a) In same Chapter, e.g. as shown in Fig 2.3.5 (i.e. Chapter, Section and Figure Number).
- (b) In same Part but different Chapter, e.g. as shown in Fig. 2.3.5 in Chapter 2.
- (c) In another Part, e.g. see Table 2.7.1 in Pt 3, Ch 2.

Rules updating

The Rules are generally published annually and changed through a system of Notices. Subscribers are forwarded copies of such Notices when the Rules change.

Current changes to Rules that appeared in Notices are shown with a black rule alongside the amended paragraph on the left hand side. A solid black rule indicates amendments and a dotted black rule indicates corrigenda.

July 2008

Chapter Contents

Part 4

PART	1	REGULATIONS
PART	2	RULES FOR THE MANUFACTURE, TESTING AND CERTIFICATION OF MATERIALS
PART	3	CONSTRUCTION, DESIGN AND TESTING REQUIREMENTS
PART	4	ENGINEERING SYSTEMS
	Chapter 1	General Requirements for the Design and Construction of Engineering Systems
	2	Electrical Systems
	3	Control and Safety of Engineering Systems
	4	Piping and Pressure Vessel Design Requirements
	5	Piping Systems

© Lloyd's Register of Shipping, 2008. All rights reserved.

Except as permitted under current legislation no part of this work may be photocopied, stored in a retrieval system, published, performed in public, adapted, broadcast, transmitted, recorded or reproduced in any form or by any means, without the prior permission of the copyright owner. Enquiries should be addressed to Lloyd's Register of Shipping, 71 Fenchurch Street, London, EC3M 4BS.

CHAPTER	1	GENERAL REQUIREMENTS FOR THE DESIGN AND CONSTRUCTION OF ENGINEERING SYSTEMS
Section	1	General
	1.1	Systems and components to be constructed under survey
	1.2	Alternative system to survey under construction
	1.3	Systems to be installed and tested under survey
	1.4	Materials
Section	2	Information to be submitted
	2.1	General
	2.2	Control and safety systems
	2.3	Electrical systems
	2.4	Piping systems
	2.5	Pressure vessels
CHAPTER	2	ELECTRICAL SYSTEMS
Section	1	General
	1.1	General requirements
	1.2	Location and construction of equipment
	1.3	Sources of electrical power
	1.4	Fire safety stops
	1.5	Cable installation
CHAPTER	3	CONTROL AND SAFETY OF ENGINEERING SYSTEMS
Section	1	General
	1.1	General requirements
	1.2	Design
	1.3	Installation and testing
Section	2	Engineering systems, control and safeguards
	2.1	Control of equipment
	2.2	Safeguards
CHAPTER	4	PIPING AND PRESSURE VESSEL DESIGN REQUIREMENTS
Section	1	General
	1.1	General requirements
Section	2	Pressure vessels
	2.1	Design
Section	3	Class of pipes
	3.1	General
	3.2	Design pressure
	3.3	Design temperature
Section	4	Carbon steels
	4.1	General
	4.2	Steel pipe joints
	4.3	Welded-on flanges, butt welded joints and fabricated branch pieces
	4.4	Screwed fittings
	4.5	Threaded sleeve joints (parallel thread)
	4.6	Socket weld joints
	4.7	Welded sleeve joints

Contents

Part 4

Section	5	Copper and copper alloys
	5.1	General
	5.2	Heat treatment
Section	6	Cast iron
	6.1	General
Section	7	Stainless steel
	7.1	General
Section	8	Plastics
	8.1	General
	8.2	Design and performance criteria
	8.3	Design strength
	8.4	Fire performance criteria
	8.5	Electrical conductivity
	8.6	Installation and construction
	8.7	Testing
Section	9	Material certificates
	9.1	Metallic materials
	9.2	Non-metallic materials
Section	10	Requirements for valves
	10.1	General
Section	11	Requirements for flexible hoses
	11.1	General
	11.2	Applications for rubber hoses
Section	12	Hydraulic tests on pipes and fittings
	12.1	Hydraulic tests before installation
	12.2	Testing after assembly
CHAPTER	5	PIPING SYSTEMS
Section	1	General
	1.1	General requirements
Section	2	Construction and installation
	2.1	Materials
	2.2	Installation
	2.3	Provision for expansion
Section	3	Shell fittings
	3.1	Construction
Section	4	Bilge pumping and drainage systems
	4.1	General
	4.2	Bilge drainage of machinery spaces
	4.3	Size of bilge suction pipes
	4.4	Pumps on bilge service and their connections
	4.5	Prevention of communication between compartments

Section	5	Air, overflow and sounding pipes
	5.1	General
	5.2	Termination of air pipes
	5.3	Air pipe closing appliances
	5.4	Nameplates
	5.5	Size of air pipes
	5.6	Overflow pipes
	5.7	Combined air and overflow systems
	5.8	Sounding arrangements
	5.9	Termination of sounding pipes
	5.10	Short sounding pipes
Section	6	Water ballast systems
	6.1	System arrangements
Section	7	Hydraulic systems
	7.1	System arrangements
Section	8	Compressed air systems
	8.1	System arrangements

General Requirements for the Design and Construction of Engineering Systems

Part 4, Chapter 1

Sections 1 & 2

Section

1 General

2 Information to be submitted

■ Section 1 General

1.1 Systems and components to be constructed under survey

1.1.1 For linkspans built under Special Survey machinery items are to be surveyed at the manufacturer's works. The workmanship is to be to the LR Surveyor's satisfaction. These items are those essential to the operation or safety of the linkspan and include any bilge and ballast pumps, air compressors, air receivers and other pressure vessels covered by Ch 4,2.1.1, hydraulic pumps and winches.

1.2 Alternative system to survey under construction

1.2.1 Alternative methods of survey at the manufacturer's works will be considered.

1.3 Systems to be installed and tested under survey

1.3.1 All items and associated systems required for the operation or safety of the linkspan are to be installed and tested under survey, including where applicable, ballast and bilge pumps and systems, air compressors and receivers or other pressure vessels, hydraulic pumps and winches.

1.4 Materials

1.4.1 The materials used in the construction are to be manufactured and tested in accordance with the requirements of the *Rules for the Manufacture, Testing and Certification of Materials*.

■ Section 2 Information to be submitted

2.1 General

2.1.1 Before work is commenced, plans in triplicate of the information listed in 2.2 to 2.5 are to be submitted to LR for approval.

2.2 Control and safety systems

2.2.1 Details of the following control systems and safeguards:

- (a) Description of operation with explanatory diagrams as appropriate.
- (b) Schematic diagrams of control circuits.
- (c) Environmental specification of items of control and safety equipment.
- (d) Test schedules, including methods of test and required test results.

2.2.2 Items of equipment under control including:

- (a) Air compressors used in ballasting.
- (b) Bilge and ballast pumps.
- (c) Hydraulic pumps and motors for positioning.
- (d) Electrical motors for positioning.
- (e) Auxiliary engines and ancillary systems.
- (f) Winches.
- (g) Hydraulic actuators.
- (h) Remotely or automatically controlled doors, gates or lifting equipment.
- (j) Other automatic or remote means of positioning.

2.3 Electrical systems

2.3.1 Single line diagram of power and lighting systems which is to include:

- (a) ratings of machines, transformers, batteries and semi-conductor converters,
- (b) all feeders connected to the switchboards,
- (c) section boards and distribution boards,
- (d) insulation type, size and current loadings of cables,
- (e) make, type and rating of circuit breakers and fuses.

2.3.2 Simplified diagrams of generator circuits, if fitted, interconnector circuits and feeder circuits showing:

- (a) protective devices, e.g. short circuit, overload, reverse power protection,
- (b) instrumentation and synchronizing devices,
- (c) preference tripping,
- (d) remote stops, and
- (e) earth fault indication/protection.

2.3.3 Calculations of short circuit currents at switchboards and section boards including those fed from transformers, details of circuit breaker and fuse operating times and discrimination curves.

2.3.4 Schedule of normal and emergency loads on the system estimated for the different conditions expected.

2.4 Piping systems

2.4.1 Venting, sounding and drainage arrangements for all spaces.

General Requirements for the Design and Construction of Engineering Systems

Part 4, Chapter 1

Section 2

2.4.2 The following diagrammatic plans including details of the material and pipe dimensions/thickness:

- (a) Bilge and ballast system including the capacities of the pumps on bilge service.
- (b) Hydraulic oil and other flammable liquid systems.
- (c) Compressed air systems.
- (d) Any other system installed which is necessary for the operation of the facility.

2.4.3 Where it is intended to use plastics pipes for Class I, Class II and any Class III systems for which there are requirements in these Rules, details of the following:

- (a) Properties of the materials.
- (b) Operating conditions.
- (c) Intended service and location.
- (d) Pipes, fittings and joints.

2.4.4 Design details of the following components:

- (a) Flexible hoses.
- (b) Sounding devices.
- (c) Resiliently seated valves.
- (d) Expansion joints.

2.5 Pressure vessels

2.5.1 Plans of pressure vessels where the conditions detailed in Ch 4,2.1.1 apply.

2.5.2 Plans of full constructional features of the vessel and dimensional details of the weld preparations for longitudinal and circumferential seams and attachments, together with particulars of the welding consumables and of the mechanical properties of the materials, are to be submitted before construction is commenced.

Electrical Systems

Part 4, Chapter 2

Section 1

Section

1 General

■ Section 1 General

1.1 General requirements

1.1.1 The electrical installation is to be designed, installed and tested in accordance with IEC Publication 364 *Electrical Installations of Buildings* or other acceptable and relevant National Regulations or Standards for electrical installations.

1.1.2 A 'Completion and Inspection' certificate for the electrical installation verifying that the requirements of the relevant regulations have been met is to be provided to LR by an accredited body before the installation is put in service.

1.2 Location and construction of equipment

1.2.1 Electrical equipment is, as far as is practicable, to be accessibly placed, clear of flammable material, in well ventilated and adequately lit spaces where flammable gases cannot accumulate and where it is not exposed to risk of mechanical injury or damage from water, oil, etc. Where necessarily exposed to such risks, the equipment is to be suitably constructed or enclosed. Live parts are to be guarded where necessary.

1.3 Sources of electrical power

1.3.1 The source of electrical power provided is to have sufficient capacity to supply all electrical services necessary to maintain the facility in the normal operating condition and to have sufficient reserve capacity to permit the starting of the largest motor without causing any motor to stall or any device to fail due to excessive voltage drop on the system.

1.4 Fire safety stops

1.4.1 Means are to be provided, at a location outside the space concerned, for stopping machinery space ventilation fans and oil pumps in the event of a fire.

1.5 Cable installation

1.5.1 Electric cables for fixed wiring are to be designed, manufactured and tested in accordance with a relevant IEC Publication or an acceptable and relevant National Standard.

1.5.2 Electric cables exposed to risk of mechanical damage are to be protected by suitable protective casings unless the protective covering (e.g. armour or sheath) is sufficient to withstand the possible cause of damage.

1.5.3 Where electric cables are installed in damp or wet locations or may be exposed to oil or harmful vapours e.g. in machinery spaces, they are to have the conductor insulating materials enclosed in an impervious sheath of material appropriate to the expected ambient conditions.

1.5.4 Electric cables are to be effectively supported and secured, without being damaged, by means of flame retardant clips, saddles or straps.

Section

1 General

2 Engineering systems, control and safeguards

■ Section 1 General

1.1 General requirements

1.1.1 The requirements of this Chapter apply to the design and construction of safety and control engineering systems.

1.1.2 Compliance with acceptable National Standards which are applicable to the design and construction of safety and control engineering systems on linkspan installations will be considered for classification purposes.

1.2 Design

1.2.1 Systems are to be designed to facilitate safe and effective control under normal operational conditions and are to provide appropriate safeguards in the event of system faults or abnormal operating conditions.

1.3 Installation and testing

1.3.1 Control systems and safeguards are to be installed and tested under LR survey.

■ Section 2 Engineering systems, control and safeguards

2.1 Control of equipment

2.1.1 Control systems are to be such that all equipment under control will operate correctly within intended working ranges and will not be subject to detrimental overload or other unintended modes of operation.

2.1.2 Control systems are to be designed to fail-safe, evaluated on the safety requirements of the complete installation.

2.1.3 Control stations are to be located and arranged such that equipment may be effectively controlled by the operator. All information required by the operator for effective control is to be provided at the control station, including indication of status of equipment under control and the presence of unrectified faults.

2.1.4 Where remote or automatic controls are employed, alternative means of operation are to be provided. This may be achieved by local manual control arrangements, subject to all necessary information being available locally.

2.1.5 Failure of any remote or automatic control system is to be indicated at the control station. Further remote or automatic operation is to be prevented until the fault has been cleared and the system manually reset.

2.1.6 Where it is intended that equipment be controlled from more than one location, appropriate interlocks are to be provided to ensure that control is possible from only one control station at any time.

2.1.7 Where a sequence of operations is to be followed automatically, means are to be provided to ensure that all necessary conditions are fulfilled before commencing each stage of the sequence.

2.2 Safeguards

2.2.1 Where failure, malfunction or improper operation of the control system may result in an unsafe situation, independent safeguards are to be provided to prevent damage to the equipment under control or injury to persons.

2.2.2 Safeguards are to be independent of the control system and designed to be fail-safe, evaluated on the safety requirements of the complete installation.

2.2.3 Where means are provided to override safeguards, arrangements are to be provided to prevent inadvertent operation of the override. Visual indication is to be provided at the control station at all times when the override is in operation.

2.2.4 Where safeguards rely on a power supply for operation, indication of power supply status is to be provided at the control station.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Sections 1, 2 & 3

Section

- 1 **General**
- 2 **Pressure vessels**
- 3 **Class of pipes**
- 4 **Carbon steels**
- 5 **Copper and copper alloys**
- 6 **Cast iron**
- 7 **Stainless steel**
- 8 **Plastics**
- 9 **Material certificates**
- 10 **Requirements for valves**
- 11 **Requirements for flexible hoses**
- 12 **Hydraulic tests on pipes and fittings**

■ Section 1 General

1.1 General requirements

1.1.1 The requirements of this Chapter apply to the design of pressure vessels and the design and construction of piping systems including pipe fittings forming part of such systems.

■ Section 2 Pressure vessels

2.1 Design

2.1.1 All pressure vessels where the conditions either (a) or (b) detailed below apply are to be designed in accordance with a pressure vessel standard acceptable to LR:

- (a) The vessels contain vapours or gases, e.g. air receivers, hydrophore or similar vessels and CO₂ vessels for fire-fighting, and

$$pV > 600$$

$$p > 1$$

$$V > 100$$

- (b) The vessel contains liquefied gases, for fire-fighting or flammable liquids, and

$$p > 7$$

$$V > 100$$

where

V = volume in litres

p = design pressure in bar.

■ Section 3 Class of pipes

3.1 General

3.1.1 Pipework systems are divided into three classes depending on the internal fluid and design temperature and pressure of the system.

3.1.2 Material requirements for the different classes of pipe are detailed in the *Rules for the Manufacture, Testing and Certification of Materials* (hereinafter referred to as the Rules for Materials).

3.1.3 Acceptable jointing methods for the different classes of pipe are given in the appropriate Section of this Chapter. Material certificate requirements are given in Section 9.

3.1.4 The maximum design pressure and temperature for Class II and III systems are given in Table 4.3.1.

Table 4.3.1 Maximum pressure and temperature conditions for Class II and III piping systems

Piping system	Class II		Class III	
	p	T	p	T
	bar	°C	bar	°C
Flammable liquids (see Note)	16,0	150	7,0	60
Other media	40,0	300	16,0	200
NOTE Flammable liquids include hydraulic oil.				

3.1.5 Class I pipes are to be used where either the maximum design pressure or design temperature exceeds that applicable to Class II pipes.

3.1.6 Class III pipes may also be used for open ended piping, e.g. overflows, vents, open-ended drains, sounding pipes, etc.

3.2 Design pressure

3.2.1 The design pressure, p , is the maximum permissible working pressure and is to be not less than the highest set pressure of the safety valve or relief valve.

3.3 Design temperature

3.3.1 The design temperature, T , is to be taken as the maximum temperature of the internal fluid, but in no case is it to be less than 50°C.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Section 4

Section 4 Carbon steels

4.1 General

4.1.1 The minimum thickness of steel pressure pipes is to be in accordance with an acceptable pressure piping code or standard except that in no case is it to be less than shown in Table 4.4.1.

Table 4.4.1 Minimum thickness for steel pipes

External diameter <i>D</i> mm	Minimum pipe thickness mm
10,2 – 12	1,6
13,5 – 19	1,8
20 – 44,5	2,0
48,3 – 53,5	2,3
70 – 82,5	2,6
88,9 – 108	2,9
114,3 – 127	3,2
133 – 139,7	3,6
152,4 – 168,3	4,0
177,8 and over	4,5

NOTES

1. The thickness of air, overflow and sounding pipes for structural tanks is to be not less than 4,5 mm.
2. The thickness of bilge, ballast and general sea water pipes is to be not less than 4,5 mm.
3. The thickness of bilge, air, overflow and sounding pipes through ballast tanks and ballast lines through ballast tanks is to be not less than 6,3 mm.
4. For air, bilge, ballast, overflow, sounding, and venting pipes as mentioned in notes 1 to 3, where the pipes are efficiently protected against corrosion, the thickness may be reduced by not more than 1 mm.

4.1.2 For pipes passing through tanks, where the thickness has been determined in accordance with 4.1.1, an additional corrosion allowance is to be added to take account of external corrosion; the addition will depend on the external medium and the value is to be in accordance with Table 4.4.2.

Table 4.4.2 Values of corrosion allowance for steel pipes

Piping service	Corrosion allowance (mm)
Compressed air systems	1,0
Hydraulic oil systems	0,3
Fresh water systems	0,8
Sea-water systems in general	3,0

4.1.3 Where the pipes are efficiently protected against corrosion, the corrosion allowance may be reduced by not more than 50 per cent.

4.1.4 Steel stub pipes between the shell plating and the sea valve are to be of short rigid construction, adequately supported and of substantial thickness.

4.2 Steel pipe joints

4.2.1 Joints in steel pipelines may be made by:

- (a) Screwed on, or welded on, bolted flanges.
- (b) Butt welds between pipes or between pipes and valve chests.
- (c) Socket welded joints.
- (d) Threaded sleeve joints (parallel thread) (see also 4.5).
- (e) Special types of approved joints that have been shown to be suitable for the design conditions (see also 4.4).

4.2.2 Where pipes are joined by welding, a suitable number of flanged joints are to be provided at suitable positions to facilitate installation and removal for maintenance.

4.2.3 For welded pipes protected against corrosion, the corrosion protection is to be applied after welding or made good in way of the weld damaged area.

4.2.4 Where it is not possible to make good the corrosion protection of the weld damaged area, the pipe is to be considered to have no corrosion protection.

4.2.5 Where backing rings are used for welding pipes, the effect of the flow obstruction of the backing ring and erosion/crevice corrosion of the backing ring is to be taken into account.

4.3 Welded-on flanges, butt welded joints and fabricated branch pieces

4.3.1 The dimensions and material of flanges and bolting, and the pressure-temperature rating of bolted flanges in pressure pipelines is to be in accordance with a recognized National or other established Standard.

4.3.2 The types of welded-on flanges are to be suitable for the pressure, temperature and service for which the pipes are intended.

4.3.3 Welded-on flanges are not to be a tight fit on the pipes. The maximum clearance between the bore of the flange and the outside diameter of the pipe is to be 3 mm at any point, and the sum of diametrically opposite clearances is not to exceed 5 mm.

4.3.4 Where butt welds are employed in the attachment of necked flanges in pipe-to-pipe joints or in the construction of branch pieces, the adjacent pieces are to be matched at the bores. This may be effected by drifting, roller expanding or machining, provided that the pipe wall is not reduced below the design thickness. If the parts to be joined differ in wall thickness, the thicker wall is to be gradually tapered to the thickness of the thinner at the butt joint. The welding necks of valve chests are to be sufficiently long to ensure that the valves are not distorted as the result of welding and subsequent heat treatment of the joints.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Sections 4 & 5

4.3.5 Where backing rings are used with a necked flange they are to fit closely to the bore of the pipe and are to be removed after welding. The rings are to be made of the same material as the pipes or of mild steel having a sulphur content not greater than 0,05 per cent.

4.3.6 Branches may be attached to pressure pipes by means of welding, provided that the pipe is reinforced at the branch by a compensating plate or collar or other approved means, or alternatively that the thickness of pipe and branch is increased to maintain the strength of the pipe. These requirements also apply to fabricated branch pieces.

4.4 Screwed fittings

4.4.1 Screwed fittings, including compression fittings, may be used in piping systems not exceeding 41 mm outside diameter. Where the fittings are not in accordance with an acceptable standard then LR may require the fittings to be subjected to special tests to demonstrate their suitability.

4.5 Threaded sleeve joints (parallel thread)

4.5.1 Threaded sleeve joints in accordance with a recognized National or other established standard may be used in Class III piping systems. They are not to be used in piping systems conveying flammable liquids.

4.6 Socket weld joints

4.6.1 Socket weld joints may be used in Class I and Class II piping systems with carbon steel pipes up to 50 mm nominal diameter, and in Class III systems for any pipe diameter. Socket weld fittings are to be of forged steel and the material is to be compatible with the associated piping. Such joints are not to be used where fatigue, severe erosion or crevice corrosion is expected to occur.

4.6.2 The thickness of the socket weld fittings is to meet the requirements of 4.1.1 but is to be not less than 1,25 times the nominal thickness of the pipe or tube. The diametrical clearance between the outside diameter of the pipe and the bore of the fitting is not to exceed 0,8 mm, and a gap of approximately 1,5 mm is to be provided between the end of the pipe and the bottom of the socket.

4.6.3 The leg lengths of the fillet weld connecting the pipe to the socket weld fitting are to be such that the throat dimensions of the weld are not less than the nominal thickness of the pipe or tube.

4.7 Welded sleeve joints

4.7.1 Welded sleeve joints may be used in Class III systems only, subject to the restrictions and general dimensional requirements stated in 4.6 for socket weld joints.

4.7.2 The pipe ends are to be located in the centre of the sleeve with a 1,5 to 2,0 mm gap.

Section 5 Copper and copper alloys

5.1 General

5.1.1 Copper and copper alloy pipes are acceptable for a wide range of services, including bilge pipework and where non heat-sensitive material is required.

5.1.2 The maximum permissible service temperature of copper and copper alloy pipes, valves and fittings is not to exceed 200°C for copper and aluminum brass and 300°C for copper-nickel. Cast bronze valves and fittings complying with the requirements of Chapter 9 of the Rules for Materials may be accepted up to 260°C.

5.1.3 The minimum thickness of copper and copper alloy pressure pipes is to be in accordance with an acceptable pressure piping code or standard except that in no case is it to be less than that shown in Table 4.5.1.

Table 4.5.1 Minimum thickness for copper and copper alloy pipes

Standard pipe sizes (outside diameter) mm	Minimum overriding nominal thickness	
	Copper mm	Copper alloy mm
8 to 10	1,0	0,8
12 to 20	1,2	1,0
25 to 44,5	1,5	1,2
50 to 76,1	2,0	1,5
88,9 to 108	2,5	2,0
133 to 159	3,0	2,5
193,7 to 267	3,5	3,0
273 to 457,2	4,0	3,5
508 and over	4,5	4,0

5.1.4 Pipes are to be seamless, and branches are to be provided by cast or stamped fittings, pipe pressing or other approved fabrications.

5.1.5 Brazing and welding materials are to be suitable for the operating temperature and for the medium being carried.

5.1.6 Where silver brazing is used, strength is to be obtained by means of the bond in a capillary space over the whole area of the mating surfaces. A fillet braze at the back of the flange or at the face is undesirable. The alloy used for silver brazing is to contain not less than 49 per cent silver.

5.1.7 The use of copper-zinc brazing alloy is not permitted.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Sections 5, 6, 7 & 8

5.2 Heat treatment

5.2.1 Pipes which have been hardened by cold bending are to be suitably heat treated on completion of manufacture and prior to testing by hydraulic pressure. Copper pipes are to be annealed and copper alloy pipes are to be either annealed or stress relief heat treated.

Section 6 Cast iron

6.1 General

6.1.1 Grey cast iron valves and fittings will, in general, be accepted in Class III piping systems except as stated in 6.1.6.

6.1.2 Consideration will be given to the acceptance of grey cast iron for valve bodies and parts in Class I hydraulic oil piping systems where failure would not render the system inoperative or introduce a fire risk.

6.1.3 Spheroidal or nodular graphite iron castings for valves and fittings in Class II and Class III piping systems are to be made in a grade having a specified minimum elongation not less than 12 per cent of a gauge length of $5,65\sqrt{S_0}$, where S_0 is the actual cross-sectional area of the test piece.

6.1.4 Proposals for the use of spheroidal graphite iron in Class I piping systems will be considered, but in no case is the material to be used in systems where the design temperature exceeds 350°C.

6.1.5 Where the elongation is less than the minimum required by 6.1.3, the material is, in general, to be subject to the same limitations as grey cast iron.

6.1.6 Grey cast iron is not to be used for the following:

- Valves and fittings for piping systems subject to shock or vibration.
- Shell valves and fittings.

Section 7 Stainless steel

7.1 General

7.1.1 The minimum thickness of stainless steel pipes in Class I and II piping systems is to be in accordance with an acceptable pressure piping standard using a suitable corrosion allowance.

7.1.2 In no case is the thickness of stainless steel pipes to be less than that shown in Table 4.7.1.

Table 4.7.1 Minimum thickness for stainless steel pipes

Standard pipe sizes (outside diameter) (mm)	Minimum nominal thickness (mm)
8,0 to 10,0	0,8
12,0 to 20,0	1,0
25,0 to 44,5	1,2
50,0 to 76,1	1,5
88,9 to 108,0	2,0
133,0 to 159,0	2,5
193,7 to 267,0	3,0
273,0 to 457,2	3,5

7.1.3 Joints in stainless steel pipework may be made by any of the techniques described in 4.2 to 4.7.

7.1.4 Where pipework is butt welded, this should preferably be accomplished without the use of backing rings, in order to eliminate the possibility of crevice corrosion between the backing ring and pipe.

Section 8 Plastics

8.1 General

8.1.1 Proposals to use plastics pipes will be considered in relation to the properties of the materials, the operating conditions and the intended service and location.

8.1.2 Plastics pipes and fittings will, in general, be accepted in Class III piping systems.

8.1.3 Plastics pipes are not acceptable for oil fuel, lubricating oil or other flammable liquid systems in machinery spaces and other spaces of high fire risk.

8.1.4 For Class I, Class II and any Class III piping systems for which there are Rules requirements, the pipes are to be of a type which has been approved by LR.

8.2 Design and performance criteria

8.2.1 Pipes and fittings are to comply with a recognized National or other established Standard, consistent with the intended use. Particulars of pipes, fittings and joints are to be submitted for consideration.

8.2.2 The design and performance criteria of all piping systems, independent of service or location, are to meet the requirements of 8.3.

8.2.3 Depending on the service and location, the fire safety aspects such as fire endurance, flame spread, smoke generation, toxicity and fire protection coatings, are to meet the requirements of 8.4.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Section 8

8.3 Design strength

8.3.1 The strength of pipes is to be determined by hydrostatic pressure tests to failure on representative sizes of pipe. The strength of fittings is to be not less than the strength of the pipes.

8.3.2 In service, the pipe is not to be subjected to a pressure greater than the nominal internal pressure pN_i .

8.3.3 The nominal internal pressure, pN_i , of the pipe is to be determined by the lesser of the following:

$$pN_i \leq \frac{P_{st}}{4}$$

$$pN_i \leq \frac{P_{lt}}{2,5}$$

where

P_{st} = short term hydrostatic test failure pressure, in bar

P_{lt} = long term hydrostatic test failure pressure (100 000 h), in bar

Due to the length of time stipulated for the long term test, testing may be carried out over a reduced period of time and the results extrapolated using a suitable standard such as ASTM D2837 and ASTM D1598.

8.3.4 The nominal external pressure, pN_e , of the pipe, defined as the maximum total of internal vacuum and external static pressure head to which the pipe may be subjected, is to be determined by the following:

$$pN_e \leq \frac{P_{col}}{3}$$

where

P_{col} = pipe collapse pressure in bar

The pipe collapse pressure is to be not less than 3 bar.

8.3.5 Piping is to meet the design requirements of 8.3.2 to 8.3.4 over the range of service temperature it will experience.

8.3.6 High temperature limits and pressure reductions relative to nominal pressures are to be in accordance with a recognized standard, but in each case the maximum working temperature is to be at least 20°C lower than the minimum temperature of deflection under load of the resin or plastics material without reinforcement. The minimum temperature of deflection under load is not to be less than 80°C.

8.3.7 Where it is proposed to use plastics piping in low temperature service, design strength testing is to be made at a temperature 10°C lower than the minimum working temperature.

8.3.8 For guidance, typical temperature and pressure limits are indicated in Tables 4.8.1 and 4.8.2. The Tables are related to water service only.

Table 4.8.1 Typical temperature and pressure limits for thermoplastic pipes

Material	Nominal pressure, bar	Maximum permissible working pressure, bar						
		-20°C to 0°C	30°C	40°C	50°C	60°C	70°C	80°C
PVC	10 16		7,5 12	6 9	6			
ABS	10 16	7,5 12	7,5 12	7 10,5	6 9	7,5	6	
HDPE	10 16	7,5 12	6 9,5	6				

Table 4.8.2 Typical temperature and pressure limits for glassfibre reinforced epoxy (GRE) and glass fibre reinforced polyester (GRP) pipes

Minimum temperature of deflection under load of resin	Nominal pressure, bar	Maximum permissible working pressure, bar							
		-50°C to 30°C	40°C	50°C	60°C	70°C	80°C	90°C	95°C
80°C	10 16 25	10 16 16	9 14 16	7,5 12 16	6 9,5 15				
100°C	10 16 25	10 16 16	9,5 15 16	10 16 16	8,5 13,5 16	7 11 16	6 9,5 15		
135°C	10 16 25	10 16 16	10 16 16	10 16 16	10 16 16	9,5 15 16	8,5 13,5 16	7 11 16	6 9,5 15

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Sections 8 & 9

8.3.9 The selection of plastics materials for piping is to take account of other factors such as impact resistance, ageing, fatigue, erosion resistance, fluid absorption and material compatibility such that the design strength of the piping is not reduced below that required by these Rules.

8.3.10 Design strength values may be verified experimentally or by a combination of testing and calculation methods.

8.4 Fire performance criteria

8.4.1 Where plastics pipes are used in systems essential for the safe operation of the linkspan or for containing combustible fluids or sea-water where leakage or failure could result in fire or in the flooding of watertight compartments, the pipes and fittings are to be of a type which has been fire endurance tested. (See also 8.2.3.)

8.4.2 All pipes, except those fitted on open decks and within tanks, cofferdams, void spaces, pipe tunnels and ducts are to have low flame spread characteristics as determined by an acceptable test procedure.

8.4.3 Pipes within service and control spaces are not to be capable of producing excessive quantities of smoke and toxic products.

8.4.4 Where a fire protective coating of pipes and fittings is necessary for achieving the fire endurance standards required, the coating is to be resistant to products likely to come into contact with the piping and be suitable for the intended application.

8.5 Electrical conductivity

8.5.1 Plastics piping is to be electrically conductive when:

- (a) Carrying fluids capable of generating electrostatic charges.
- (b) Passing through dangerous zones and spaces, regardless of the fluid being conveyed.

Suitable precautions against the build up of electrostatic charges are to be provided.

8.5.2 Where a piping system is required to be electrically conductive for the control of static electricity, the resistance per unit length of the pipe, bends, elbows, fabricated branch pieces, etc., is not to exceed 0,1 MΩ/m. Electrical continuity is to be maintained across the joints and fittings, and the system is to be earthed.

8.5.3 Where a piping system is required to be electrically conductive, tests are to be carried out to verify that the resistance to earth from any point in the system does not exceed 1 MΩ.

8.6 Installation and construction

8.6.1 All pipes are to be adequately but freely supported. Suitable provision is to be made for expansion and contraction to take place without unduly straining the pipes.

8.6.2 Pipes may be joined by mechanical couplings or bonding methods such as welding, laminating, adhesive bonding or other approved means.

8.6.3 Sufficient mechanical joints are to be provided to enable the pipes to be readily removed.

8.6.4 The required fire endurance level of the pipe is to be maintained in way of pipe supports, joints and fittings, including those between plastics and metallic pipes.

8.6.5 Where piping systems are arranged to pass through watertight bulkheads or decks, provision is to be made for maintaining the integrity of the bulkhead or deck by means of metallic bulkhead pieces. The bulkhead pieces are to be of substantial construction and suitably protected against corrosion and so constructed to be of a strength equivalent to the intact bulkhead; attention is drawn to 8.6.1. Details of the arrangements are to be submitted for approval.

8.7 Testing

8.7.1 The hydraulic testing of pipes and fittings is to be in accordance with Section 12.

Section 9 Material certificates

9.1 Metallic materials

9.1.1 Materials for Class I and II piping systems and components, as defined in Table 4.3.1, and also the material for shell valves and fittings are to be manufactured and tested in accordance with the Rules for Materials.

9.1.2 Ferrous castings and forgings for Class I and II piping systems are to be produced at a works approved by LR.

9.1.3 Materials for Class III piping systems are to be manufactured and tested in accordance with the requirements of acceptable National Standards.

9.1.4 The manufacturer's materials test certificate will be accepted for all classes of piping and components in lieu of an LR materials certificate where the maximum design conditions are less than shown in Table 4.9.1.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Sections 9, 10, 11 & 12

Table 4.9.1 Maximum conditions for pipes, valves and fittings for which Manufacturer's materials test certificate is acceptable

Material	Working temperature °C	DN = nominal diameter, mm P _w = working pressure, bar
Carbon and low alloy steel. Stainless steel. Spheroidal or nodular cast iron.	<300	DN < 50 or P _w × DN < 2500
Copper alloy	<200 or P _w × DN < 1500	DN < 50

9.2 Non-metallic materials

9.2.1 Pipes and fittings intended for applications in Class I, Class II and Class III systems for which there are Rule requirements are to be manufactured in accordance with the Rules for Materials.

Section 10 Requirements for valves

10.1 General

10.1.1 All valves are to be so constructed as to prevent the possibility of valve covers or glands being slackened back or loosened when the valves are operated.

10.1.2 All valves are to be arranged to shut with a right-hand (clockwise) motion of the wheels and are to be provided with indicators showing whether they are open or shut unless this is readily obvious.

10.1.3 Valves and cocks are to be fitted with legible nameplates and, except for submerged valves in ballast systems, are to be fitted in places where they are at all times readily accessible.

10.1.4 Shell valves are to be fitted in accessible positions and are to be capable of being operated from positions which are readily accessible in case of influx of water to the compartment.

10.1.5 Valve hand wheels and cock handles are to be suitably retained on the spindles.

10.1.6 Shell valves are to be hydraulically tested before installation in accordance with Section 12.

10.1.7 All valves which are provided with remote control are to be arranged for local manual operation, independent of the remote operating mechanism.

10.1.8 Valves having isolation or sealing components sensitive to heat are not to be used in spaces where leakage or failure caused by fire could result in fire spread, flooding or the loss of an essential service.

Section 11 Requirements for flexible hoses

11.1 General

11.1.1 Short joining lengths of flexible hoses of approved type may be used, where necessary, to accommodate relative movement between various items of machinery connected to permanent piping systems.

11.1.2 Prototype pressure tests are to be carried out on each new type of hose, complete with end fittings, and in no case is the bursting pressure to be less than five times the maximum working pressure in service.

11.2 Applications for rubber hoses

11.2.1 Synthetic rubber hoses, with integral cotton or similar braid reinforcement, may be used in fresh and sea water systems, but not for fire extinguishing salt water services.

11.2.2 Synthetic rubber hoses for use in bilge, ballast, compressed air, hydraulic oil and other flammable liquid systems are to have single or double closely woven integral wire braid reinforcement or be otherwise inherently fire resistant and of an approved fire tested type.

Section 12 Hydraulic tests on pipes and fittings

12.1 Hydraulic tests before installation

12.1.1 All Class I and II pipes and their associated fittings are to be tested by hydraulic pressure. Further, compressed air and flammable liquid pipes, together with their fittings, are to be similarly tested where the design pressure is greater than 7 bar. The test is to be carried out after completion of manufacture and before installation and, where applicable, before insulating and coating.

12.1.2 The test pressure is to be 1.5 times the design pressure, as defined in 3.2.

12.1.3 Valves, cocks and distance pieces intended for installation on the shell are to be tested by hydraulic pressure to not less than 5 bar.

Piping and Pressure Vessel Design Requirements

Part 4, Chapter 4

Section 12

12.2 Testing after assembly

12.2.1 Flammable liquid piping is to be tested by hydraulic pressure, after installation, to 1,5 times the design pressure but in no case to less than 3,5 bar.

12.2.2 Where pipes specified in 12.1.1 are butt welded together during assembly, they are to be tested by hydraulic pressure, in accordance with the requirements of 12.2.1, after welding. The pipe lengths may be insulated, except in way of the joints made during installation and before the hydraulic test is carried out.

12.2.3 The hydraulic test required by 12.2.2 may be omitted provided satisfactory non-destructive tests by ultrasonic or radiographic methods are carried out on the entire circumference of all butt welds.

12.2.4 Where ultrasonic tests have been carried out, the manufacturer is to provide the Surveyor with a signed statement confirming that ultrasonic examination has been carried out by an approved operator and that there were no indications of defects which could be expected to have a detrimental effect on the service performance of the piping.

Piping Systems

Part 4, Chapter 5

Sections 1, 2, 3 & 4

Section

- 1 **General**
- 2 **Construction and installation**
- 3 **Shell fittings**
- 4 **Bilge pumping and drainage systems**
- 5 **Air, overflow and sounding pipes**
- 6 **Water ballast systems**
- 7 **Hydraulic systems**
- 8 **Compressed air systems**

2.2.4 After installation, all hydraulic, compressed air and other piping systems together with associated fittings are to be subjected to a running test at the design operating conditions.

2.3 Provision for expansion

2.3.1 Suitable provision for expansion is to be made, where necessary, in each range of pipes.

2.3.2 Where expansion pieces are fitted, arrangements are to be provided to protect against over extension and compression. The adjoining pieces are to be suitably aligned, supported, guided and anchored. Where necessary, expansion pieces of the bellows type are to be protected against mechanical damage.

■ Section 1 General

1.1 General requirements

1.1.1 The requirements of this Chapter apply to piping systems on all types of linkspans.

1.1.2 Consideration will be given to special cases or to arrangements which are equivalent to those required by these Rules.

■ Section 3 Shell fittings

3.1 Construction

3.1.1 All sea inlet and overboard discharge pipes are to be fitted with valves or cocks secured direct to the pontoon shell or to fabricated water boxes attached to the shell plating.

3.1.2 Distance pieces of short rigid construction and made of approved material may be fitted between the valve and shell. The thickness of such distance pieces is to be equivalent to the pontoon shell thickness.

3.1.3 The arrangements are to be such that the section of pipe immediately inboard of the shell valve may be removed without affecting the watertight integrity of the structure.

■ Section 2 Construction and installation

2.1 Materials

2.1.1 Except where otherwise stated in this Chapter, pipes valves and fittings are to be made of steel, cast iron, copper alloy, or other approved material suitable for the intended service.

2.1.2 Where applicable, the materials are to comply with the relevant requirements of Chapter 4.

2.2 Installation

2.2.1 All pipes for essential services are to be secured in position to prevent chafing or lateral movement.

2.2.2 Long or heavy lengths of pipe are to be supported by bearers so that no undue load is carried by pipe connections or pumps and fittings to which they are attached.

2.2.3 All pipes situated in positions where they are liable to mechanical damage are to be efficiently protected.

■ Section 4 Bilge pumping and drainage systems

4.1 General

4.1.1 Arrangements are to be made for draining all watertight compartments other than those intended for permanent storage of fluids. Where drainage is not considered necessary, drainage arrangements may be omitted provided the safety of the linkspan is not impaired.

4.1.2 Pumping arrangements are to be provided having suctions and means of drainage so arranged that any water within any watertight compartment of the linkspan or any watertight section of any compartment, can be pumped out through at least one suction under all possible conditions of operation.

Piping Systems

Part 4, Chapter 5

Sections 4 & 5

4.1.3 The bilge pumping system is to be designed to prevent water flowing from one watertight compartment to another.

4.1.4 Small compartments may be drained by individual hand pump suction.

4.1.5 Where the safety or operation of the linkspan could be affected by the ingress of water into a space provided with bilge pumping arrangements, the space is to be provided with a bilge level alarm.

4.2 Bilge drainage of machinery spaces

4.2.1 The bilge drainage arrangements are to comply with 4.1, except that the arrangements are to be such that any water which may enter this compartment can be pumped out through at least two bilge suction under all possible design operating and survival conditions.

4.2.2 Where a bilge main is fitted, one of the suction referred to in 4.2.1 is to be a branch bilge suction, i.e. a suction connected to the bilge main. The second bilge suction is to be a direct bilge suction.

4.2.3 Where a bilge main is not fitted, the branch bilge suction referred to in 4.2.2 may be replaced by a suction from a submersible bilge pump.

4.2.4 Additional bilge suction may be required for the drainage of wells or other recesses.

4.3 Size of bilge suction pipes

4.3.1 The sizes of bilge suction pipes are to be suitable for the dimensions of the spaces requiring bilge drainage arrangements.

4.3.2 Where a bilge main is fitted, the internal diameter is to be not less than 50 mm.

4.3.3 The diameter of branch bilge suction is to be not less than 25 mm.

4.4 Pumps on bilge service and their connections

4.4.1 Not less than one power pump and one manual bilge pump suitable for bilge pumping duties are to be provided. Each pump is to take suction from the bilge main or other bilge system arrangement for draining all spaces as applicable.

4.4.2 The power driven pumps may be used for other services (other than flammable liquid transfer) but they are to be immediately available for bilge duty when required.

4.4.3 Pumps required for essential services are not to be connected to a common suction or discharge chest or pipe unless the arrangements are such that the working of any pumps so connected is unaffected by the other pumps being in operation at the same time.

4.4.4 Each power operated bilge pumping unit is to be capable of giving a speed of water through the bilge suction piping of not less than 2 m/s.

4.5 Prevention of communication between compartments

4.5.1 The arrangement of valves, cocks and their connections is to be such as to prevent the possibility of one watertight compartment being placed in communication with another, or machinery spaces or other dry compartments being placed in communication with the sea or with tanks. For this purpose, screw-down non-return valves are to be provided in the following fittings:

- (a) Bilge valve distribution chests.
- (b) Direct bilge suction and bilge pump connections to main bilge line.

4.5.2 Bilge suction pipes are to be entirely separate from sea inlets or from pipes which may be used for filling or emptying spaces where water or oil is carried.

Section 5 Air, overflow and sounding pipes

5.1 General

5.1.1 Air pipes are to be fitted to all tanks, cofferdams, and other compartments which are not fitted with alternative ventilation arrangements.

5.1.2 Air pipes are to be fitted at the opposite end of the tank to that which the filling pipes are placed and/or at the highest part of the tank. Where the tank top is of unusual or irregular profile, consideration will be given to the number and position of the air pipes.

5.1.3 Air pipes to tanks containing flammable liquids which are located in or pass through compartments of high fire risk, or are in the open, are to be of steel or other equivalent material.

5.2 Termination of air pipes

5.2.1 Air pipes to tanks and cofferdams extending to the shell plating, or tanks which can be run up from the sea are to be led to above the weather deck.

5.2.2 Air pipes from storage tanks containing hydraulic oil may terminate in the machinery space, provided the open ends are so situated that issuing oil cannot come into contact with electrical equipment or heated surfaces.

Piping Systems

Part 4, Chapter 5

Sections 5 & 6

5.3 Air pipe closing appliances

5.3.1 Closing appliances fitted to tank air pipes are to be of a type which will allow the free passage of air or liquid to prevent the tanks being subjected to a pressure or vacuum greater than that for which they are designed.

5.3.2 Air pipe closing devices are to be of a type acceptable to LR and are to be tested in accordance with a National or International Standard recognized by LR. The flow characteristic of the closing device is to be determined using water. See 5.5.

5.3.3 If closing appliances are not fitted, air pipes are to be fitted with a goose neck at the open end.

5.4 Nameplates

5.4.1 Nameplates are to be affixed to the upper ends of all air and sounding pipes.

5.5 Size of air pipes

5.5.1 In all cases, whether a tank is filled by on-board pumps or other means, the total cross-sectional area of air pipes is to be not less than 25 per cent greater than the effective area of the respective filling pipe.

5.5.2 Air pipes are to be generally not less than 38 mm bore. In the case of small gravity filled tanks smaller bore pipes may be accepted but in no case is the bore to be less than 25 mm.

5.6 Overflow pipes

5.6.1 For all tanks which can be pumped up, overflow pipes are to be fitted where the pressure head corresponding to the height of the air pipe is greater than that for which the tank is designed

5.6.2 In the case of tanks containing flammable liquids, the overflow pipe is to be led to an overflow tank of adequate capacity or to a storage tank having a space reserved for overflow purposes. Suitable means are to be provided to indicate when overflow is occurring.

5.6.3 Overflow pipes are to be self draining under normal conditions of operation.

5.6.4 Where overflow sight glasses are provided, they are to be in a vertical dropping line and designed such that the oil does not impinge on the glass. The glass is to be of heat resisting quality and adequately protected from mechanical damage.

5.7 Combined air and overflow systems

5.7.1 Where a combined air or overflow system is fitted, the arrangement is to be such that in the event of any one of the tanks being bilged, the other tanks cannot be flooded from the sea through combined air pipes or the overflow main. For this purpose, it will normally be necessary to lead the overflow pipe to a point above the waterline.

5.7.2 Where a common overflow main is provided, the main is to be sized to allow any two tanks connected to that main to overflow simultaneously.

5.8 Sounding arrangements

5.8.1 Provision is to be made for sounding all tanks and the bilges of those compartments which are not at all times readily accessible. The soundings are to be taken as near the suction pipes as practicable.

5.8.2 An approved level gauge or remote reading level device may be accepted in lieu of a sounding pipe.

5.8.3 Sounding pipes are to be not less than 32 mm internal diameter.

5.9 Termination of sounding pipes

5.9.1 Except as permitted by 5.10, sounding pipes are to be led to positions which are at all times accessible above the weather deck and, in the case of tanks containing flammable liquids, the sounding pipes are to be led to safe positions in the open.

5.10 Short sounding pipes

5.10.1 In machinery spaces, where it is not practicable to extend sounding pipes as mentioned in 5.9, short sounding pipes extending to readily accessible positions above the platform may be fitted.

5.10.2 Short sounding pipes to oil tanks are to be fitted with cocks having parallel plugs with permanently attached handles, so loaded that, on being released, they automatically close the cocks.

Section 6 Water ballast systems

6.1 System arrangements

6.1.1 Spaces intended for ballast are to be provided with suitable means for filling and emptying.

6.1.2 Where the ballasting is adjusted using compressed air, means are to be provided to protect the tanks against over-pressure.

Piping Systems

Part 4, Chapter 5

Sections 6, 7 & 8

6.1.3 The arrangements for discharging water ballast are to be such that any ballast tank may be discharged by the use of alternative drainage arrangements.

6.1.4 Ballast piping arrangements are to be separate and distinct from other piping systems.

8.1.4 Pipelines which are situated on the low pressure side of reducing valves, and which are not designed to withstand the full pressure at the source of supply, are to be fitted with pressure gauges and with relief valves having sufficient discharge capacity to protect the piping against excessive pressure.

■ Section 7 Hydraulic systems

7.1 System arrangements

7.1.1 Hydraulic fluids are to be suitable for the intended purpose under all operating service conditions.

7.1.2 Materials used for all parts of hydraulic seals are to be compatible with the working fluid at the appropriate working temperature and pressure.

7.1.3 Over-pressure protection is to be provided on the discharge side of all pumps. Where relief valves are fitted for this purpose they are to be fitted in closed circuit, i.e. arranged to discharge back to the system oil tank.

7.1.4 Provision is to be made for hand operation of the systems in an emergency, unless an acceptable alternative is available.

7.1.5 Where hydraulic securing is applied, the system is to be mechanically lockable in the closed position so that, in the event of hydraulic system failure, the securing arrangement will remain locked.

■ Section 8 Compressed air systems

8.1 System arrangements

8.1.1 Where compressed air is utilized for adjusting ballast or for other operational purposes, the requirements of 8.1.2 to 8.1.4 are to be complied with.

8.1.2 If compressed air is the only means of adjusting ballast or is utilized for other essential operational purposes, at least two sources of air supply are to be provided.

8.1.3 Stop valves in compressed air supply lines to closed piping systems are to permit slow opening to avoid sudden pressure rises in piping systems.

© Lloyd's Register, 2008
Published by Lloyd's Register
Registered office
71 Fenchurch Street, London, EC3M 4BS
United Kingdom